No.99MBC095A
SERIES No.544

LSM-6200

Laser Scan Micrometer (Display Unit)

User's Manual

Read this User's Manual thoroughly
before operating the instrument. After reading,
retain it close at hand for future reference.

Mitutoyo

CONVENTIONS USED IN USER'S MANUAL

Safety Precautions

To operate the instrument correctly and safely, Mitutoyo manuals use various safety signs (Signal Words and Safety Alert Symbols) to identify and warn against hazards and potential accidents.

The following signs indicate **general** warnings:

DANGER

Indicates an imminently hazardous situation which, if not avoided, will result in serious injury or death.

WARNING

Indicates a potentially hazardous situation which, if not avoided, could result in serious injury or death.

CAUTION

Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury or property damage.

The following signs indicate **specific** warnings or prohibited actions, or indicate a mandatory action:

Alerts the user to a specific hazardous situation. The given example means “Caution, risk of electric shock”.

Prohibits a specific action. The given example means “ Do not disassemble”.

Specifies a required action. The given example means “Ground”.

CONVENTIONS USED IN USER'S MANUAL

On Various Types of Notes

The following types of **notes** are provided to help the operator obtain reliable measurement data through correct instrument operation.

IMPORTANT
- An important note is a type of note that provides information essential to the completion of a task. You cannot disregard this note to complete the task.
- An important note is a type of precaution, which if neglected could result in a loss of data, decreased accuracy or instrument malfunction/failure.

NOTE A note emphasizes or supplements important points of the main text. A note supplies information that may only apply in special cases (e.g.. Memory limitations, equipment configurations, or details that apply to specific versions of a program).

TIP A tip is a type of note that helps the user apply the techniques and procedures described in the text to their specific needs.
It also provides reference information associated with the topic being discussed.

NOTES FOR EXPORTING

Before exporting this product confirm the final purpose of use at the export destination to prevent the product from being used for developing weapons of mass destruction or military affairs. In the case of export to the U.S., this product requires an application for prior approval of CDRH (Center for Devices and Radiological Health) in FDA (Food and Drug Administration). For detailed information consult a Mitutoyo sales office. Also, if this product is exported with it incorporated in equipment, the final product requires an application for FDA approval. If this is the case, note that the client must file an application for approval.

PRECAUTIONS

1. Safety Precautions
   The Measuring Unit connected to the Display Unit uses a very low power laser.

Use of controls or adjustments or performance of procedures other than those specified herein may result in hazardous radiation exposure.

1) An applicable laser product class of the IEC standard: a Class 2 laser product uses a visible laser (maximum power: 1.3 mW for scanning; laser device: semiconductor laser; wavelength: 650 nm).
2) Do not look directly into the laser beam. (Even if it seems that no light is being emitted from the emission window, do not look into it.)
3) If measuring flat objects with mirror finishes, avoid looking at the reflection on the surface.
4) Close the beam shutter when the instrument is not in use.
5) Do not remove the laser class identification labels attached to the Measuring Unit.
6) Before using this unit, carefully read the “Measuring Unit Specifications” and “Precautions on Use of Laser” sections provided in the manual supplied with the Measuring Unit.

2. Before making the connection between the Measuring Unit and the Display Unit, turn off the power. If an optional device is to be connected to this system, make sure that the optional device is also turned off.
3. Firmly tighten the screws of the cable connectors and interfaces to ensure shielding.
4. Do not touch the terminals of the connectors, otherwise contact may be poor.
5. Positively ground the Display Unit.
6. An error display may appear during operation. However, it may not always indicate a fault. If an error display appears, consult the “Maintenance and Inspection” section.
7. Unplug the power cord when a system failure is encountered.

Do not open the covers provided on the emission unit and reception unit.

INSTALLING CONDITIONS

The Mitutoyo Laser Scan Micrometer LSM-6100 series is both a precision optical instrument and a precision electronic instrument, and this unit is the instrument suitable for indoor use as well. Therefore, it must be carefully installed and the following conditions must be taken into consideration to attain the highest possible accuracy.

1. Vibration
   Install this unit if possible in a place where it will not be subject to vibration. If this unit is used for a long period of time in an environment where there are significant vibrations, the precision parts in this unit may be affected, resulting in the deterioration of measuring accuracy.

   If this unit has to be used in an environment where vibration is significant, measures such as the laying of a vibration damping rubber pad under the unit must be applied to reduce the effect of vibration.

2. Dust
   Dust and airborne particles at the installation site adversely affect optical parts including the protective glass and electronic parts of the Measuring Unit. Place this unit in a place with as little dust and as few airborne particles as possible.

3. Direct sunlight
   If this unit is subjected to direct sunlight, the heat may deform this unit and affect the measuring accuracy.

   If this unit must be placed by a window where it will be subjected to direct sunlight, protect the unit by shading it.

4. Draft from air-conditioning equipment
   If the measuring area is subject to such as warm or cold draft from any air-conditioning equipment, the laser beam may be artificially refracted due to the unevenness of ambient air concentration, affecting the measurement accuracy.

   If this is the case, block the draft in the mid-way to the measuring area by such as a curtain, etc.

5. Ambient temperature and humidity
   This unit must be operated in an environment where the temperature is between 0 and 40˚C and the humidity is between 35 and 85% RH. Avoid installing this unit where there is significant temperature or humidity change.

   Significant temperature and humidity changes may reduce measuring accuracy.

WARRANTY

In the event that the Mitutoyo Laser Scan Micrometer (LSM) should prove defective in workmanship or material, within one year from the date of original purchase for use, it will be repaired or replaced, at our option, free of charge upon its prepaid return to us.

If the unit fails or is damaged because of the following causes it will be subject to a repair change, even if it is still under warranty.

1. Failure or damage due to inappropriate handling or unauthorized modification.
2. Failure or damage due to transport, droppage, or relocation of the machine after purchase.
3. Failure or damage due to fire, salt, gas, abnormal voltage, or natural catastrophe.

This warranty is effective only where the machine is properly installed and operated following this manual.

CONTENTS

MEMO

1 INTRODUCTION

This chapter describes the Laser Scan Micrometer (LSM) models and nomenclature of the Display unit and the Measuring unit.

1.1 Outline

This system is an accurate, non-contact measurement system capable of measuring workpiece dimensions at a high speed using a highly directional scanning laser beam.

This non-contact optical measuring system is capable of measuring workpieces which are difficult to measure with conventional measuring instruments. It performs simple and accurate measurement of brittle or elastic objects, objects at high temperature, objects which must be kept clean, and soft objects which may be deformed and suffer dimensional changes under the measuring forces used.

1.2 Foreword

This user's manual primarily explains the functions of the Display Unit. For information about the safety precautions, specifications, dimensions, standard accessories, and options for each Measuring Unit, refer to the user's manual supplied with the Measuring Unit.

1.2.1 Measuring units available

This Display Unit can be used with the following Measuring Units.

Models
LSM-500S
LSM-501S
LSM-503S
LSM-506S
LSM-512S
LSM-516S

1.2.2 Using the Measuring Unit separately

All models, excluding the LSM-500S, can be used separately (the laser emission unit and reception unit can be separated) by removing the mount from the Measuring Unit.

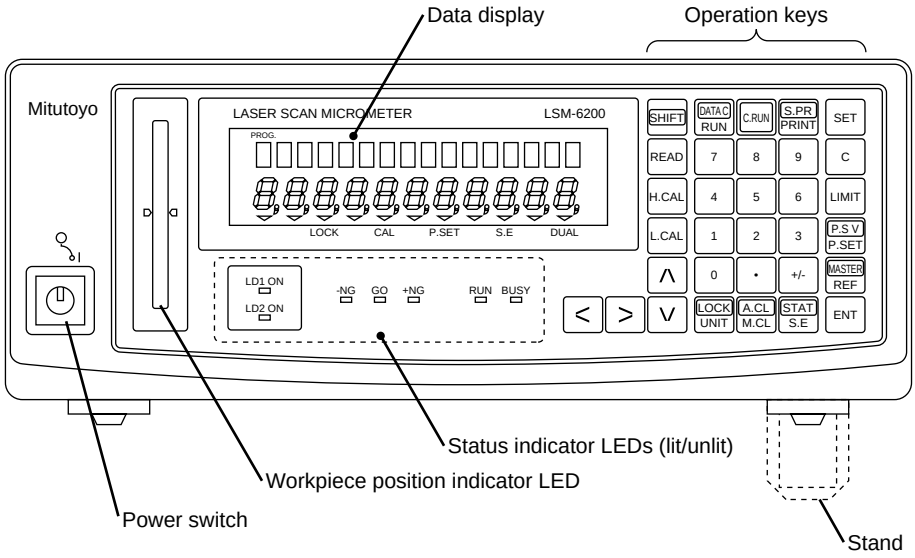
For information about using an LSM separately, refer to the measuring unit user's manual.

1.3 Nomenclature

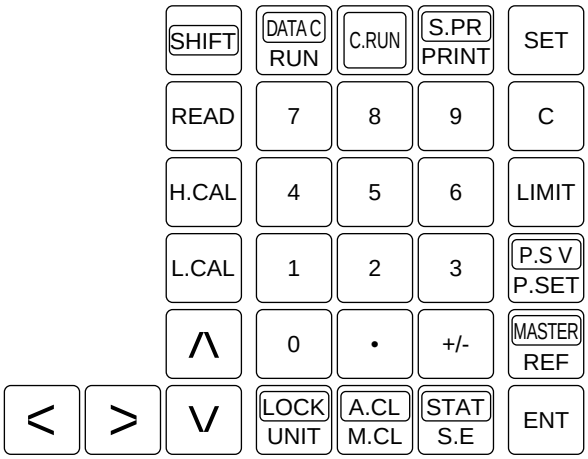
This section gives the name of each part in the LSM system.

1.3.1 Display Unit

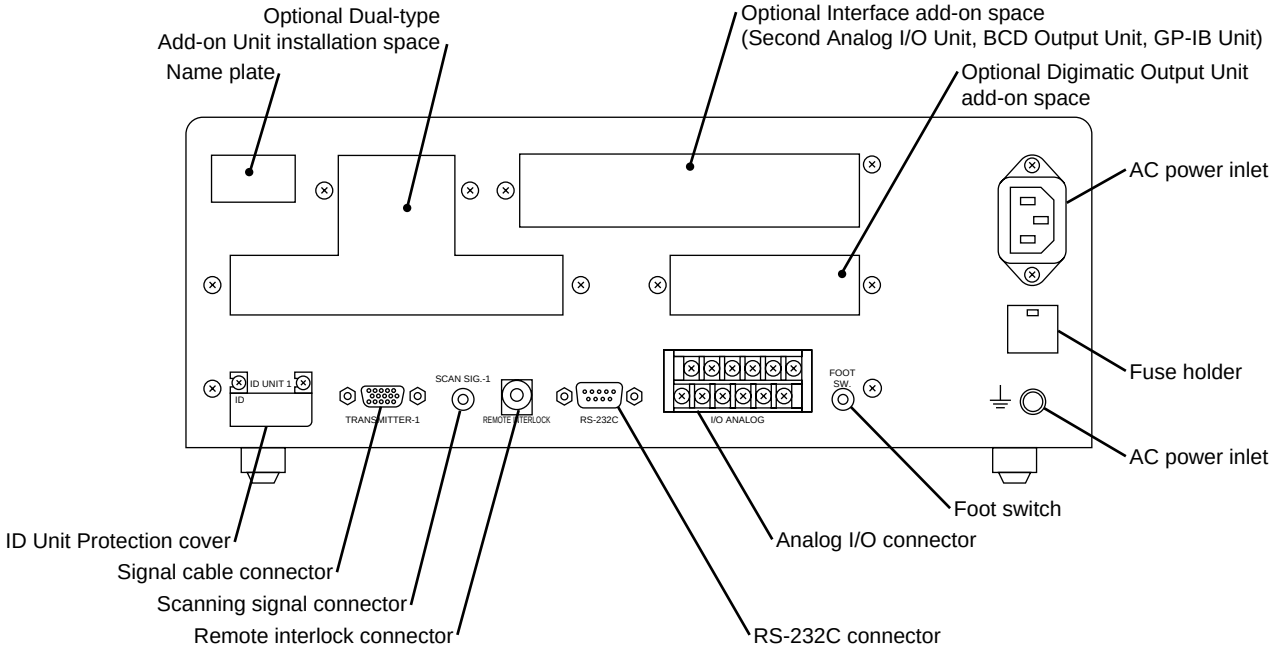
(1) Front panel



(2) Displays and keys



(3) Rear panel



TIP

1. A label which describes the terminal block name “I/O ANALOG” can be seen if the protective cover of the Analog I/O terminal block is opened. Use this for wiring.
2. The terminal located at the left end of the power input terminal and marked (by a symbol ⏚) is the grounding terminal to keep the potential of signal line of this unit equal with other instrument connected. It is used to enhance resistance against electrical interference.

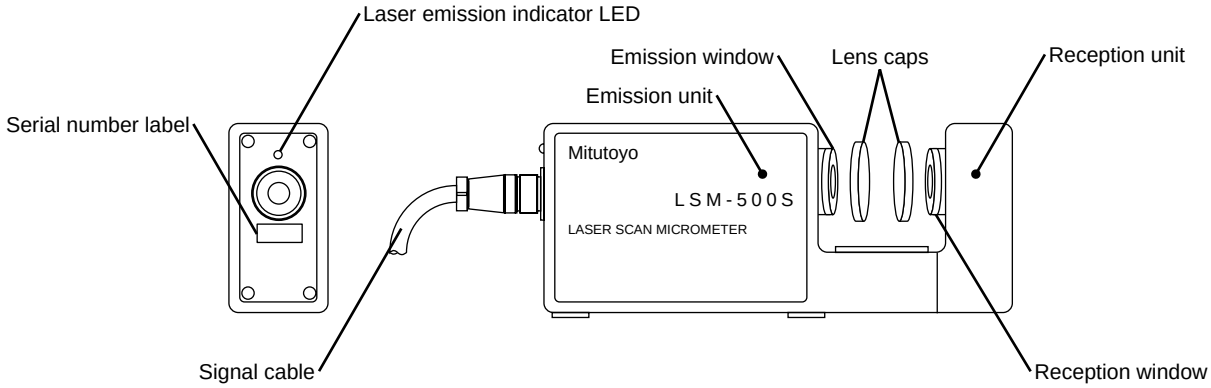
NOTE Precautions for wiring the terminal block

1. If wiring the I/O analog terminal and Power input terminal, do not directly touch the output terminals of the terminal block by hand, which has static charges, because the internal circuit may be damaged by static discharge.
   If your hands are charged, discharge the static energy by touching the metallic surface of the Display Unit in advance. In addition, unplug the power cable from the outlet before commencing wiring.
2. After wiring has been completed, close the protective cover.
3. Do not touch the input terminals on the terminal block during operation, otherwise an operation error may result.

1.3.2 Measuring Unit

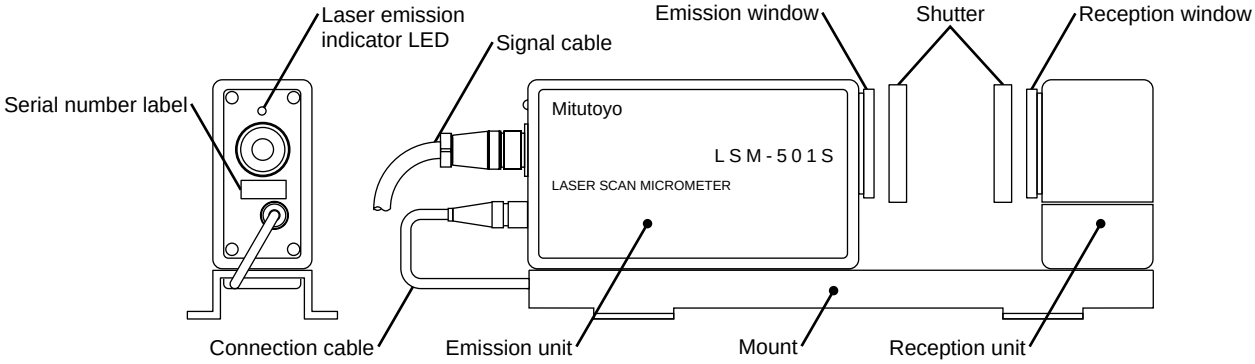
(1) Measuring Unit (integrated-type Measuring Unit)

LSM-500S



(2) Measuring Unit (separate-type Measuring Unit)

LSM-501S, 503S, 506S, 512S, 516S



2 SETUP

This chapter describes the connection between the Display Unit and Measuring Unit.

2.1 Unpacking and Acceptance Check

Your LSM has been thoroughly inspected prior to shipment. The mechanical, electrical, and optical systems are guaranteed to operate properly.

Unpack the package and check that the accessories, for the Display Unit or Measuring Unit, and signal cables, etc., are intact and not damaged.

Contact Mitutoyo if anything is damaged or missing.

2.2 Connecting the Cables

Make sure that the power switch is turned off (turn the key switch counterclockwise to align with “O”, then pull it out), then connect the cables according to the following procedure.

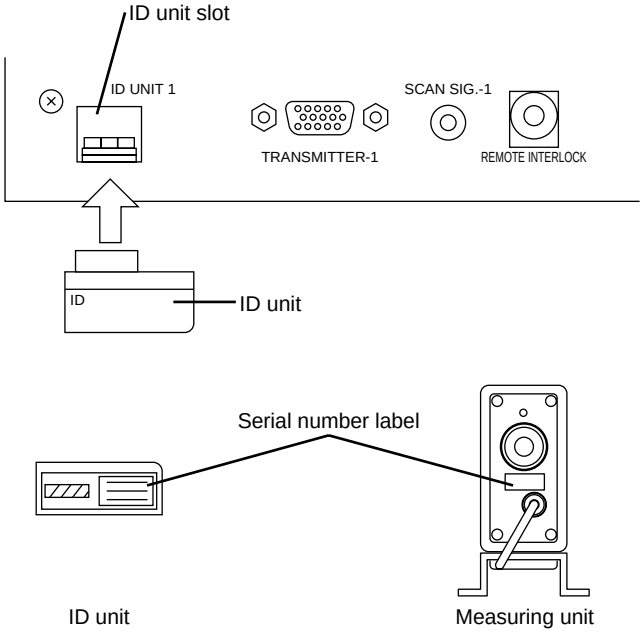
Step 1: Integrating the option interface

For the option interface (Dual-type Add-on Unit, Second Analog I/O Unit, BCD Output Unit, GP-IB Unit, and Digimatic Output Unit) to become available with the LSM, it must be installed by referring to Section 6.3 “Installing the Optional Interface Unit”.

For information about the setup switches on the BCD and GP-IB interface units refer to Section 6.2.3, “BCD Interface” and Section 6.2.4, “GP-IB Interface”, respectively.

Step 2: Attaching the ID unit

1. Loosen the two screws that secure the ID unit protection cover at the left on the real panel of the Display Unit and remove the cover by sliding it rightward.
2. Remove the dummy ID unit (amber) that has been mounted at the left of the "TRANSMITTER-1" connector on the rear panel of the Display Unit, then insert the ID unit (beige) that comes in the same package as the Measuring Unit.
   This ID unit stores critical data that ensures the accuracy of the Measuring Unit and has the same serial number as the accompanying Measuring Unit. Confirm that these two numbers are identical before inserting the ID unit.



If a Dual-type Add-on Unit is used, install the ID unit in the ID UNIT 2 slot above the ID UNIT 1.

3. Replace and secure the ID unit protection cover revering the procedures in step 1 above.

IMPORTANT

- If the dummy ID unit is still mounted, "E E ····· E E" is displayed in the lower section of the display. If this is the case, turn off the power and replace the dummy ID unit with a proper ID unit.

PROG
E E E E E E E E E E

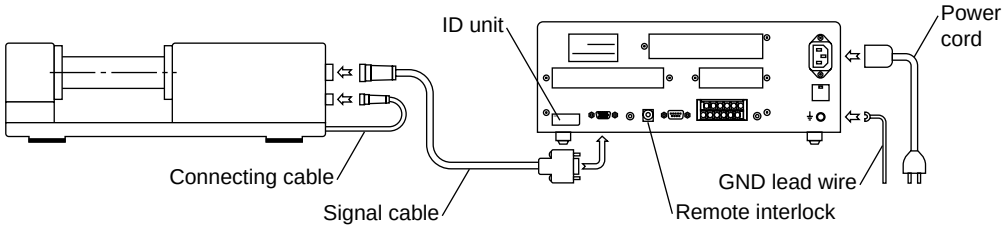
- If the ID unit has not been installed, an error display as shown at the right will appear in the upper section of the data display unit and the operation of this unit stops.

PROG
ERR-ID
C C C C C C

- If the ID unit is not installed or if the serial number of the Measuring Unit is not consistent with that on the ID unit, the system will not work and an error code as shown at the right will be displayed at power on. At the same time, the 6-digit serial number of the measuring unit is displayed for confirmation.

PROG
ERR-ID
701234

If the [C] key has been pressed to enter the ready state, measurement can be automatically started. However, the measuring accuracy can not be guaranteed. If the optional dual-type add-on unit is used to perform measurement with two Measuring Units, make sure that the serial numbers of the two Measuring Units, which are connected to the "TRANSMITTER-1" connector and "TRANSMITTER-2" connector, are identical. If neither of the two Measuring Units has a serial number identical to that of the ID unit, a serial number of the Measuring Unit on the "TRANSMITTER-1" side will be displayed in the upper display section, and that of the Measuring Unit on the "TRANSMITTER-2" side will be displayed in the lower display section.



Step 3: Connecting the connecting cable (except for the LSM-500S)
Connect the cable which runs from the base of the Measuring Unit to the lower connector (5-pin) on the rear panel of the emission unit.

Step 4: Connecting the signal cable
Insert the round plug (12-pin) of the signal cable into the upper connector (12-pin) on the rear panel of the emission unit. Tighten the ring screw to firmly secure the connectors.
Insert the square connector (15-pin) on the other end of the signal cable into the connector "TRANSMITTER-1" at the upper left of the display rear panel and tighten the securing screws.

If measurement is performed with two Measuring Units while using the optional dual-type add-on unit, plug the cable from the second Measuring Unit into the "TRANSMITTER-2" connector, then firmly tighten the screws.

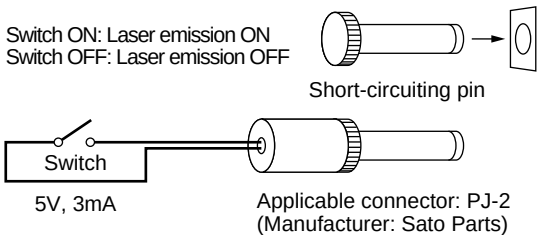
Step 5: Connecting the power cord and GND lead wire
Connect the supplied power cord to the AC connector at the upper right on the rear panel of the Display unit. Also be sure to ground the Display unit with the GND lead wire for improved resistance to noise.

Terminal to which a grounding wire is connected.
Ground the system using the provided grounding wire to avoid the effect of interference noise caused in the setup environment.

Step 6: Checking the remote interlock connector

Make sure that the short-circuiting pin is inserted into the “REMOTE INTERLOCK” connector on the rear panel of the Display Unit. If this short-circuiting pin is not inserted, laser emission is disabled, even if the power switch is on.

To emergency stop laser emission, refer to the following diagram.



NOTE Recovering operation is not guaranteed. Never use this function for other than emergency stop.

Step 7: Connecting the interface

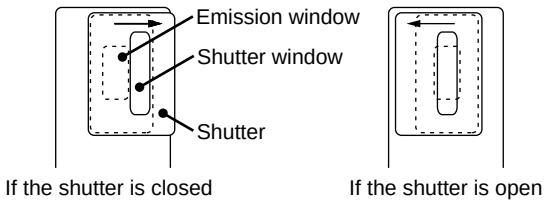
For information about the procedure used to connect the interface, refer to Section 6.1.1, “I/O Analog Interface” and Section 6.1.2, “RS-232C Interface”.

NOTE
1. Note the following when connecting the signal cable.
   For information about the precautions to be observed when connecting the signal cable refer to the measuring unit user’s manual.
2. Note the following when making cable connections.
   Always make connection or disconnection with the power cord unplugged. In addition, before connecting to the interface make sure that the power to all other units connected or to be connected are also off.

2.3 Preliminary Checks

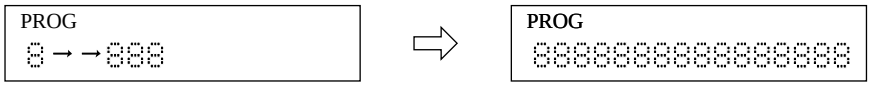
The necessary connections should be completed by following the procedure described in the previous chapter. Simplified operation checks are described here.

Step 1: Fully open the lens cap and shutter of the Measuring Unit.
Fully open the lens caps and beam shutters of both the emission unit and reception unit to ready the laser beam for emission.
The lens caps should be completely removed, and the shutters should be as shown in the diagram below.

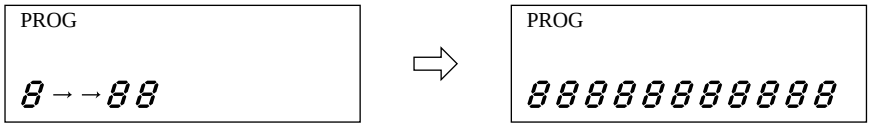


Step 2: Power on

- Turn the power key switch on the Display Unit clockwise until it is in the I (power on) position and the power is on.
- This unit enters the self check mode and all the LEDs and segments turn on. They will turn off shortly, and eights 8 will be displayed in the upper display section. When 8888···8 is displayed across the upper display section, the unit will turn off shortly. This is followed by the self check on the lower display section.

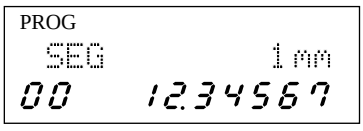


- In the lower display section eights 8 will appear sequentially from the left to right.
- After 88888888888 is displayed across the lower display section, it will turn off shortly.



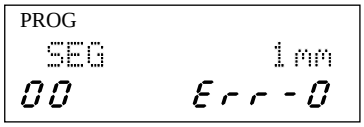
- Measurement is started.
The LD1 ON (LD1 ON and LD2 ON in the dual-unit measurement) LED turns on and the BUSY LED starts flashing to indicate the measurement has started from the ready state.

Since the objective segment has been set to "SEG 1" at the factory, the displayed measurement shows the laser scanning range of the Measuring Unit.



Here, the Display Unit is found to be normal because the scanning range is displayed.
Proceed to Chapter 3, "DISPLAYS AND KEY OPERATIONS", to custom set up each function.

- An error may be displayed at this stage, however, the display at the right is not actually an error. Check the shutter of the Measuring Unit.
  For information about other errors that may result refer to Section 8.3, “Error Messages and Remedies”.



2.4 Initializing the LSM-6200 Display Unit

After making sure that this unit is operating normally, initialize the Display Unit so it can recognize the Measuring Unit(s) to be used.

Initialization of the Display Unit is also required if the Measuring Unit needs to be changed.

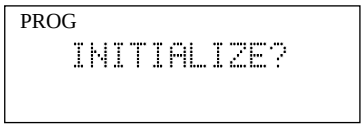
In addition to replacing the ID unit that is associated with the Measuring Unit, initialize the Display Unit (i.e. restore the factory setups) with the following procedure.

The initialization procedure is as follows:

Step 1: Turn off the power and connect the Measuring Unit with the ID unit that comes with the Measuring Unit installed.

Step 2: Turn on the power while holding down the [C] key.
Hold down the [C] key for approximately 2 seconds, even after the power is on.

Step 3: When the self check has been completed, the display shown at the right will appear. To initialize, press the [ENT] key. When the initialization process has been completed, the display restors the initial conditions that existed just after the power on.
To abort initialization press a key other than the [ENT] key or turn the power off. In the former case the initialization process will be aborted and the initial display at power-on will be restored.



NOTE Initialization will clear all the customer setup data and will restore the factory-setups. Customize the setups again as necessary.

3 DISPLAYS AND KEY OPERATIONS

This Display Unit is provided with many useful functions that can be customized according to the user's needs.

This chapter describes these functions and key operations.

3.1 Outline of the Operation Modes

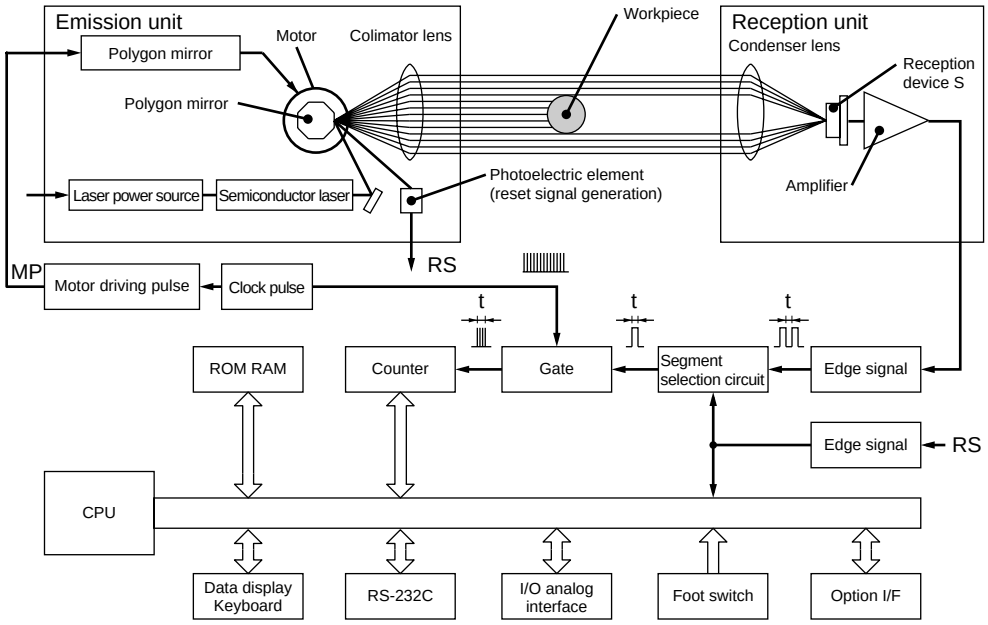
3.1.1 Measurement Principle

In order for the user to understand the measurement principle of the LSM, the following paragraphs describe about the system block diagram, segments (measurement positions) and measurement interval (measurement time).

3.1.1.1 Overview

Unlike light emitted from natural sources, a laser provides extremely fine, rectilinear beams which do not diffuse (coherent light beams).

Using the properties of the laser beam, the Mitutoyo Laser Scan Micrometer (LSM) moves a scanning laser beam over the workpiece and determines its dimensions by measuring the duration in which the beam is obstructed by the workpiece.



The configuration of the system is shown in the above block diagram. A laser beam emitted from the laser oscillator is directed at the polygon mirror which rotates at high speed and is synchronized by clock pulses. The laser beam that is reflected by the polygon mirror is then collimated by the collimator lens towards the workpiece. As the polygon mirror rotates, this horizontal beam scans the workpiece and the beam not obstructed by the workpiece will reach the photoelectric element through the condenser lens and induce an output voltage in the photoelectric element. The output voltage will change according to the duration over which the laser beam is obstructed. Counting pulses generated during that period are used to determine the dimension of the obstructed portion. This data is sent to the CPU for processing and the dimensions are displayed digitally.

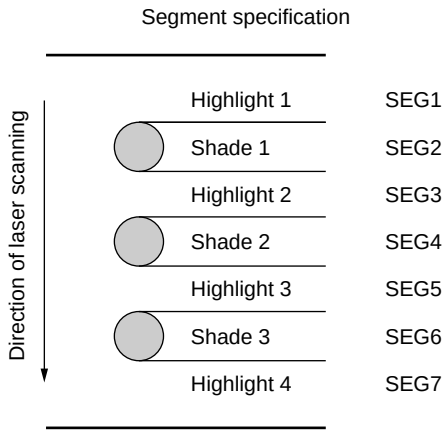
Consequently, either the dimensions of the workpiece (shadowed areas) or workpiece clearances (highlighted areas) can be determined by specifying the segments to be measured.

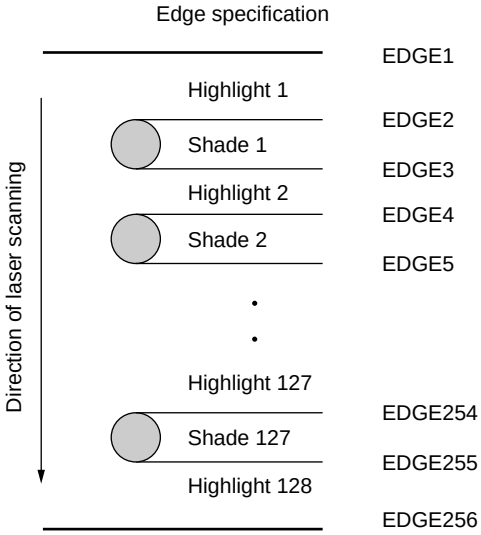
TIP In the system block diagram described in the previous page, the laser beam passed through the collimator lens is made parallel and, at the same time, stopped down so that the beam diameter is minimized at the measurement position.

3.1.1.2 Setting the segment

Set the objective portion of a workpiece to be measured.

The highlighted and shaded portions created when the laser scans over the workpiece are controlled with each assigned number. In the basic setup a selection must be made from one of two cases: case where there are 1 to 4 highlighted and shaded sections, and case where there are 1 to 127 similar sections. In the former case the portions are controlled through the segment number, and are simply called segments. In the latter case the portions are controlled by the edge number (edge number is between 1 and 255) and called edges. Edge numbers equal to or greater than 256 are not available.





- A maximum of 4 highlighted sections and a maximum of 3 shaded sections can be measured.
- Multiple segments can be specified at the same time.
- Specify segments 1 to 3 for a transparent object.

- A maximum of 127 highlighted sections and a maximum of 127 shaded sections can be measured.
- Always specify the start edge and finish edge numbers. These two edges can be either continued or separated. However, they must not be identical.
- Edge numbers can not be specified for a transparent object.
- If automatic measurement is specified in the basic setup, intervals, outside diameters, or gaps between the same shape of multiple pins can be automatically measured.

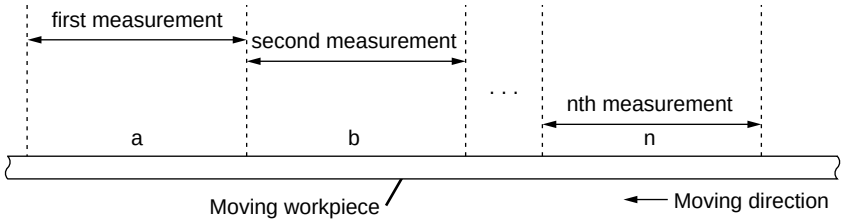
3.1.1.3 Measurement interval (measurement time)

A measurement interval (measurement time) varies depending on the averaging method and the number of scans selected for the measurement data.

There are two types of averaging method: the arithmetical average and the moving average. Select the one best suited for the user's purpose.

1) Arithmetical average

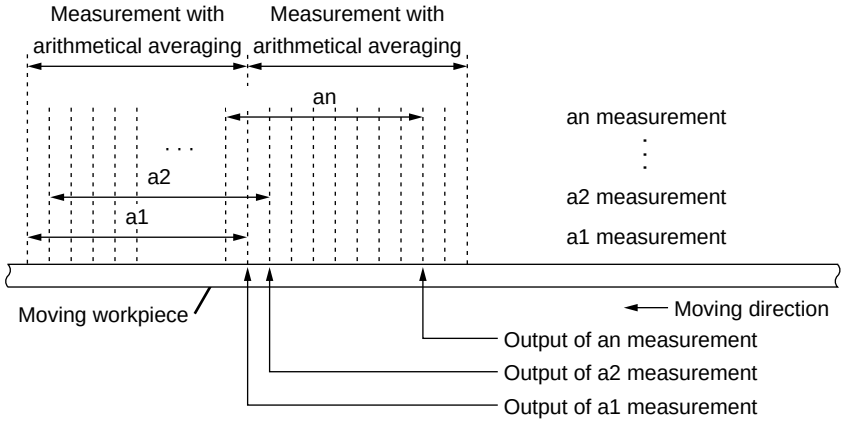
- If a moving workpiece is measured, the OD of the workpiece is determined by averaging the measured data taken from each section (a: first measurement, b: second measurement, ... n: nth measurement) of the workpiece the specified number of averaging times, as shown below.



- One of the following number of averaging times can be selected: 1, 2, 4, 8, ...1024, 2048. (If extra fine wire measurement is specified in the basic setup, the number of averaging times can be selected from between 16 and 2048.)
- This is suitable for measuring a still object or the run-out of rollers, etc.

2) Moving average

In the moving average method, a measurement interval identical to that in the arithmetical average is divided into finer sections such as a1 (1st measurement), a2 (2nd measurement), - - - , an (nth measurement). Each measurement is performed almost in parallel. If, for example, the number of averaging times is set to 512, the first measurement requires the amount of time that corresponds to 512 scans. However, for the second measurement onward, only the time for 16 scannings is required. With respect to a workpiece with a changing OD, this method provides data with smooth variation because of the many pieces of data, and also quickly detects the trend of workpiece OD variation.

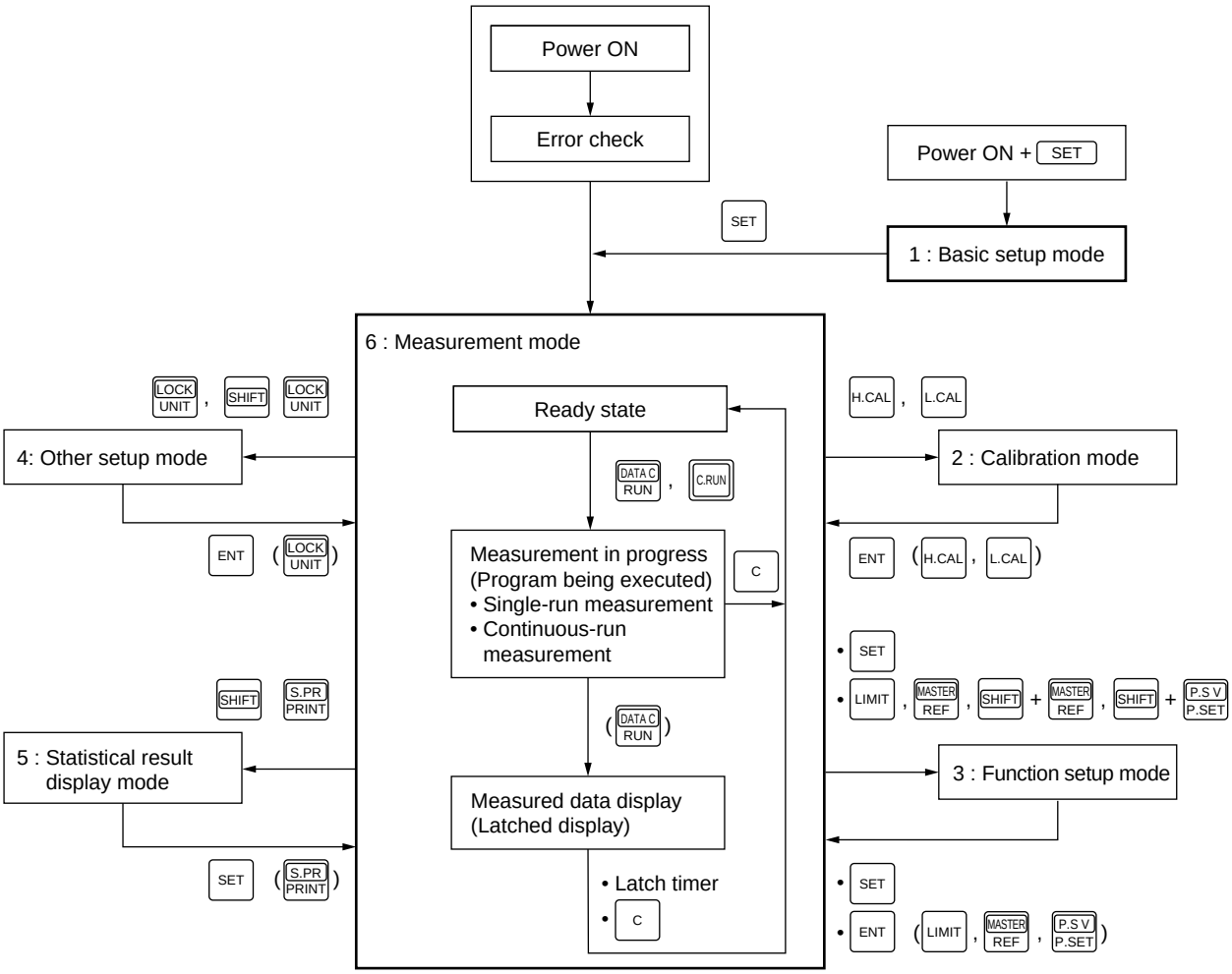


- One of the following number of scans can be selected: 32, 64, 128, ...1024, 2048.
- This method is suitable for the feedback control of wire drawing machines and extruding machines.

3.1.2 Outline of the Operation Modes

The LSM system has the following modes:

1: Basic setup mode, 2: Calibration mode, 3: Function setup mode, 4: Other setup mode, 5: Statistical result display mode, and 6: Measurement mode.



3.1.2.1 Basic setup mode

- This mode is used to customize the basic setup conditions, including the resolution, interface conditions, and available functions, according to the measurement requirements. For more information, refer to Section 4.1, “Basic Setup”.
- To enter the basic setup mode turn on the power (turn the key switch clockwise from the “O” position to the “I” position) while holding down the SET key. Hold down the key for about 2 seconds to initiate the basic setup mode.

3.1.2.2 Calibration mode

- Depending on the environment in which the LSM is used and the Display Unit - Measuring Unit combination, measurement errors may result. Therefore, always perform calibration prior to use, taking the measuring range and environmental conditions into account. If calibration is performed, the errors described above will be reduced and high accuracy will be ensured.
- Before performing calibration, always make the setups for resolution, simultaneous-measurement, dual-unit measurement and available segments in the basic setup mode. If this order is reverse, the previously set calibration values may be discarded.
- For more information, refer to Section 4.2, “Calibration”.
- Press the H.CAL key to enter the HI CAL mode; and press the L.CAL key to enter the LOW CAL mode.

3.1.2.3 Measuring condition setup mode

- This mode is used to set up measuring conditions, including segments (objective portion of workpiece to be measured) and GO/NG judgment criteria.
- Press the SET key to enable all the function setup items established to be set in a batch.
- Each of the LIMIT, SHIFT→ P.S V/P.SET, MASTER/REF, SHIFT→ MASTER/REF keys allows the individual function setup item to be established.
- Press the < key to enter the setup operation for the setup item which is used most often.

3.1.2.4 Other setup mode

- This mode is used to set the key lock and to set the unit of measurement.
- Press the SHIFT and LOCK/UNIT key to turn on and off the key lock; and press only the LOCK/UNIT key to enter the unit change mode.
- Press the SHIFT and READ key to enter the measuring position display mode.

3.1.2.5 Statistic display mode

- Displays the statistical processing results.
- Press the SHIFT and STAT/S.E keys in the ready state to enter the statistic display mode.
- Press the SHIFT and S.PR/PRINT keys in the ready state to allow the statistical processing results to be printed.

3.1.2.6 Measurement mode

This mode can be divided into the following operational states:

1) Measurement in the ready state

- This is the measurement mode that is entered immediately after the power is turned on or if another measurement mode is aborted by pressing the [C] key (or by the $\overline{\text{RESET}}$ signal from the I/O interface or the "CL" command from the RS-232C/GP-IB interface).
- It is used to establish setups for calibration and available functions, which are not part of the basic setup items, or to enter another measurement mode including single-run measurement.
- Usually GO/NG judgment and analog output will not take place for measurement in the ready state, however, these specifications can be made in the basic setup mode.
- Measurements in the ready state are unavailable for statistical processing.

2) Single-run measurement

- If the [DATA C/RUN] key (otherwise input $\overline{\text{RUN}}$ via the I/O interface or "R" command via the RS-232C/GP-IB interface) is pressed, one session of measurement is performed and the results will be automatically subject to GO/NG judgment and analog output. In addition, the measured data will be outputted for the RS-232C/GP-IB interface, Digimatic Output Unit, and printer. The measured data will be held (latched for the specified period) in the display.
- This data will be available for statistical processing.

3) Continuous-run measurement

- If the [C.RUN] key (otherwise input $\overline{\text{RUN}}$+$\overline{\text{RESET}}$ via the I/O interface or "CR" command via the RS-232C/GP-IB interface) is pressed, one session of measurement is started and repeated the specified number of times. The measured data will be automatically subject to GO/NG judgment and analog output. In addition, the measured data will be outputted for the RS-232C/GP-IB interface, Digimatic Output Unit, and printer.
- Press the [DATA C/RUN] or [C.RUN] key (or if $\overline{\text{RUN}}$ is received from the I/O interface) again to terminate the measurement and hold the measured data on the display. If the [C] key (or input $\overline{\text{RESET}}$ via the I/O interface or "CL" command via the RS-232C/GP-IB interface) is pressed halfway, the measurement is aborted and the ready state is returned to.
- The measurements are available for statistical processing.

4) Continuous measurement with a term specification

- This will take place where $\overline{\text{RUN}}$ input from the I/O interface has been assigned so as to start a term-specified continuous-run measurement in the basic setup.
- Repeatedly performs single-run measurement while $\overline{\text{RUN}}$ signal input continues, which is basically the same as the continuous-run measurement. Therefore, hereafter, continuous-run measurement includes the ones with a term specification.
- The measurements are available for statistical processing.

5) Zero-run measurement

- A measurement where the number of samples is set to "0" is called a "zero-run measurement".
- If the [DATA C/RUN] key (otherwise input $\overline{RUN}$ via the I/O interface or the "R" command via the RS-232C/GP-IB interface) is pressed, single-run measurement is started and repeated until the [DATA C/RUN] key is pressed again (or $\overline{RUN}$ is inputted via the I/O interface or the "STOP" command is inputted via the RS-232C/GP-IB interface). From the measured data the calculation items (mean, maximum value, minimum value, and range) that have been set for the sample measurement will be calculated and the resulting data will be automatically subject to GO/NG judgment and analog output. In addition, the measured data will be outputted for the RS-232C/GP-IB interface, Digimatic Output Unit, and printer. The measured data will be held on the display.
- The measured data are available for statistical processing.
- This is suitable for run-out measurement and cylindricity measurement.

6) Sample measurement

- A measurement where the number of samples is set to "2~999" is called a "sample measurement".
- In practice this will take place as a single-run measurement or a continuous-run measurement (with a term specification).
  From the measured data the calculation items (mean, maximum value, minimum value, and range) that have been set for the sample measurement will be calculated and the resulting data will be automatically subject to GO/NG judgment and analog output. In addition, the measured data will be outputted for the RS-232C/GP-IB interface, Digimatic Output Unit, and printer.
- The measured data are available for statistical processing.
- This is suitable for run-out measurement and cylindricity measurement.

7) Statistical processing

- Measured data from single-run and continuous-run measurements can be statistically processed (i.e. the number of measurement times, standard deviation, maximum value, minimum value, mean, and range are calculated).
  These statistical processing results can be outputted for the display, printer (statistical memory for all programs will be cleared after printout), and RS-232C/GP-IB interface.
- Press the [STAT/S.E] key (or input "ST" command via the RS-232C/GP-IB interface) to start statistical processing, and press it again (or input the "NST" command via the RS-232C/GP-IB interface) to terminate statistical processing.
- Performs single-run measurements or continuous-run measurements to store statistical data after statistical processing has been started.
- Pressing the [SHIFT] → [DATA C/RUN] , and [ENT] keys in this order will cancel the last measurement.
- Pressing the [SHIFT] and [STAT/S.E] keys will display the results of statistical processing. The item displayed will change each time the key [ENT] is pressed.
  The display item will change in this sequence: [N: Measurement number], [S.D: Standard deviation], [MAX: Maximum value], [MIN: Minimum value], [AVG: Mean value], and [R: Range (Max - Min)].
  Statistical processing will be performed independently for each program.
- Press the [A.CL/M.CL] key to clear the statistical memory of the foreground program (case of a simultaneous measurement), and press the [SHIFT] and [A.CL/M.CL] keys to clear the statistical memory of all the programs.
- These statistical results data will be stored in memory while the power is on, and will be lost when the power is turned off.

3.2 Techniques and Terminology of Setup Functions

3.2.1 Program

- A measurement will be automatically performed according to the registered (programmed) contents including the segment (feature to be measured) and GO/NG judgment criteria, etc., in advance. Registration is performed in the function setup mode.
- This unit can hold a maximum 100 programs, which may include various settings suitable for up to hundred kinds of workpieces.
- Program numbers are divided into groups, each of which has up to ten programs and is referred to as a channel (CH).
  These two-digit program numbers define the meanings as shown in the table below.

	Digit of ten	Digit of one
Program No.	16	
Application	Channel No.	Individual No.
	0 to 9	For each channel 0 to 9

- As the expanded basic setup it is possible to select the range of applying calibration.
  1. Applies uniformly to the entire 100 programs (factory default).
  2. Applies individually to each channel (10 programs).
- With the expanded basic setup it is possible to select the range of applying presetting and mastering.
  1. Applies uniformly to the entire 100 programs (factory default).
  2. Applies individually to each channel (10 programs).
  3. Applies individually to each program.
- As the expanded basic setup it is possible to select either the “100 Program mode” or “10 program mode”, which limits the number of available programs to ten. (The factory default setting is the 100 program mode.)
- As the basic setup it is possible to select either the “Single measurement mode” which uses 100 programs (10 programs in the 10 program mode) as independent programs or the “Simultaneous measurement mode” which uses two specific programs as a pair.

NOTE
- If the program must be switched to another with the RS-232C/GP-IB command, it is necessary to use a separate command for the 100 program mode or 10 program mode.
  For more information about the RS-232C/GP-IB command refer to Section 6.1.2.4 “RS-232C/GP-IB Commands”.
- In the 10 program mode the user can make use of the RS-232C/GP-IB commands provided for Mitutoyo old models (LSM-6000, 6100) without further modification. It is advised for the customers, who are operating Mitutoyo old models (LSM-6000, 6100) with the RS-232C communication commands, to use the 10 program mode.

a) Single measurement

One session of measurement will be performed according to the one specified program. The factory default setting is this single measurement.

b) Simultaneous measurement

- In one measurement session two specific programs are executed at one time as a pair. Combinations of program numbers to form these pairs are shown in the following table.
- To run a pair of programs, either of the two can be specified via one of the numeric keys and the one specified is called “foreground program”, and its counterpart is called “background program”.

<<Possible combinations in the 100 program mode>>

	Channel No. (Digit of ten of the program number) [0 to 4]				
Program numbers pairs	0	1	2	3	4
	00 & 05	10 & 15	20 & 25	30 & 35	40 & 45
	01 & 06	11 & 16	21 & 26	31 & 36	41 & 46
	02 & 07	12 & 17	22 & 27	32 & 37	42 & 47
	03 & 08	13 & 18	23 & 28	33 & 38	43 & 48
	04 & 09	14 & 19	24 & 29	34 & 39	44 & 49

	Channel No. (Digit of ten of the program number) [5 to 9]				
Program numbers pairs	5	6	7	8	9
	50 & 55	60 & 65	70 & 75	80 & 85	90 & 95
	51 & 56	61 & 66	71 & 76	81 & 86	91 & 96
	52 & 57	62 & 67	72 & 77	82 & 87	92 & 97
	53 & 58	63 & 68	73 & 78	83 & 88	93 & 98
	54 & 59	64 & 69	74 & 79	84 & 89	94 & 99

<< Possible combinations in the 10 program mode>>

Program numbers pairs	00 & 05
	01 & 06
	02 & 07
	03 & 08
	04 & 09

3.2.2 Basic setup

- This is used to customize the basic setup conditions, including the resolution, available functions, and interface conditions, according to the measurement requirements.
- This basic setup must be performed at the beginning of a measurement. Note that changing the setup of resolution, simultaneous measurement, or dual-unit measurement in this basic setup cancel the existing calibration values and function setup.
- The basic setup mode is entered by turning on the power while holding down the SET key.
  Note that no response will be made to an I/O interface input and RS-232C/GP-IB command in the basic setup mode.
- For more information, refer to Section 4.1, “Basic Setup”.

3.2.3 Function setup

- Use this procedure to set up the conditions necessary for measurement.]
  For each program number register measurement conditions including the segment (part feature to be measured), measurement interval (measurement time), and GO/NG judgment criteria that are the best suited for the objective workpiece.
- To enter the function setup mode press the [SET] key in the ready state. Each of the [LIMIT], [SHIFT]→ [P.S V/P.SET], [MASTER/REF], [SHIFT]→ [MASTER/REF] keys allows the individual setup item to be established, and the [<] key enters the setup operation for items which are most frequently accessed for set up.
- For more information refer to Section 4.5, “Setting Up the Functions”.

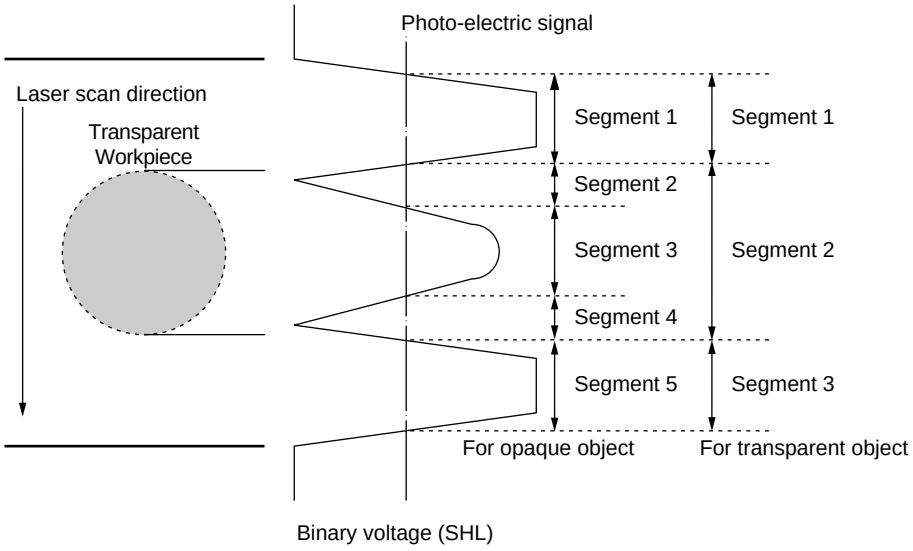
3.2.4 Setups according to the property of each workpiece

For measuring workpieces that transmit light or have a dimension smaller than the diameter of the scanning beam it is critical to make setups that take into account the properties of the workpiece.

3.2.4.1 Transparent object (Workpiece that transmits light)

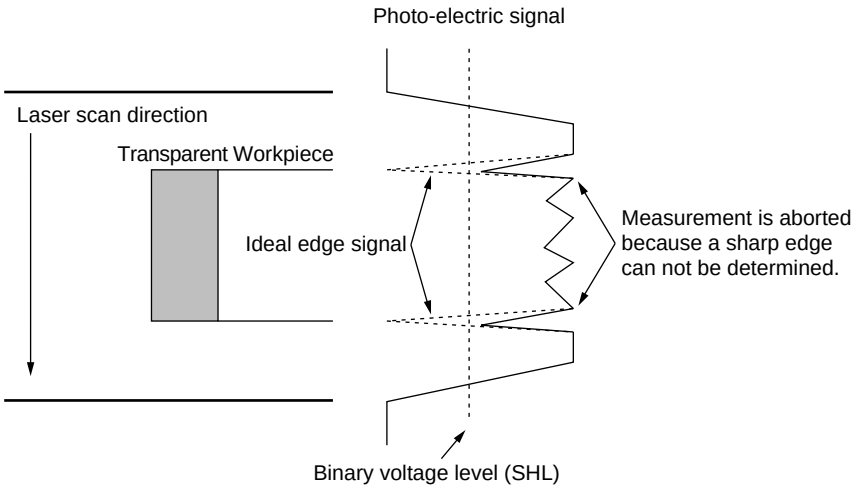
a) Round bar

- Workpieces such as fiber optics and glass tubes are more or less transparent, while workpieces made of steel are not. This requires different segment settings.
  The segment settings for an opaque object and a transparent object are as follows:
- Setup for measurement of transparent or opaque object is possible in the basic setup.



b) Plate (Sheet)

- In the case of the width measurement of a transparent plate with no chamfer on edges, measurement may not be possible since acute-edge signals cannot be produced for such edges.

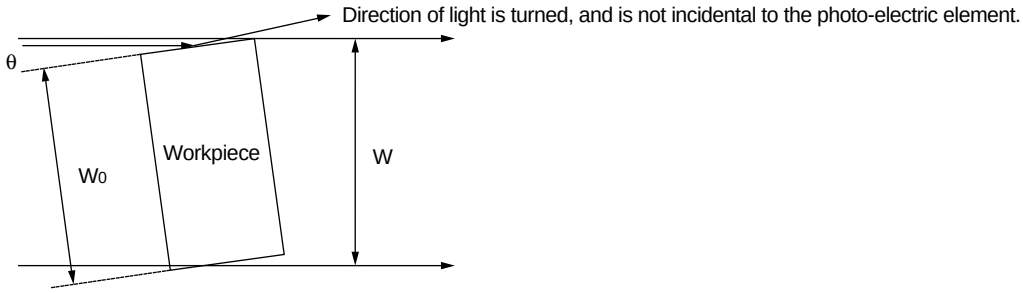


- For measuring a transparent plate-shaped workpiece
  Take the following precautions:

1. Incline the workpiece.

By inclining the workpiece it is possible to attain a sharp edge from the light contrast. In this case:

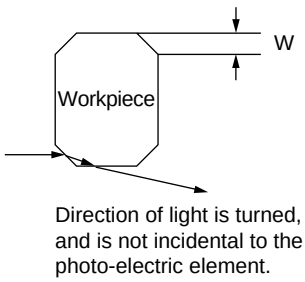
Measurement : $W = W_0$ (workpiece dimension) x $\cos \theta$



2. Chamfering

Chamfer the workpiece edge by W. W will vary depending on the model. Always use values larger than those in the table below.

Measuring Unit model	Chamfering amount: W
LSM-500S	0.1 mm
LSM-501S	0.1 mm
LSM-503S	0.2 mm
LSM-506S	0.4 mm
LSM-512S	0.8 mm
LSM-516S	1.2 mm

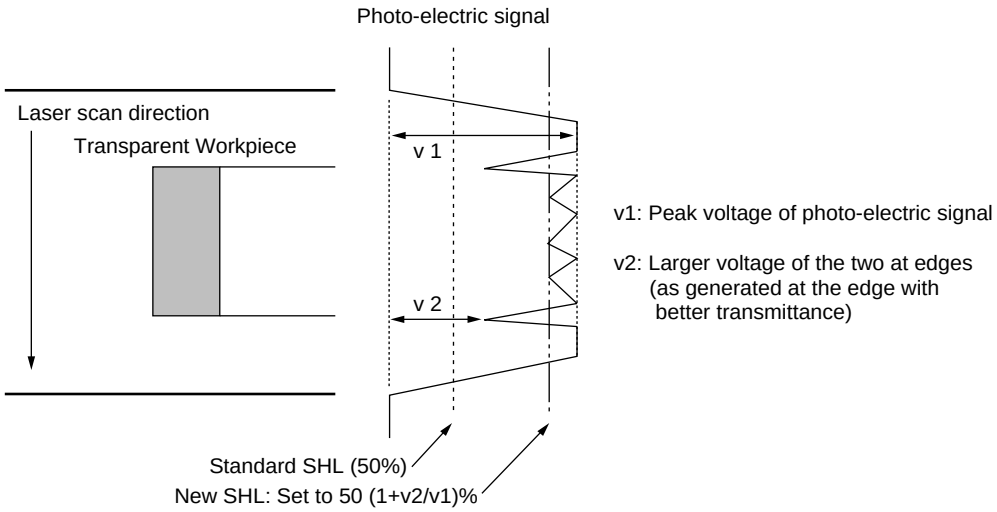


3. Changing the SHL

- With the reference workpiece set up on the Measuring Unit, connect the oscilloscope to the [SCAN SIG.] terminal on the rear panel of the Display Unit and observe the signal.
- SHL is the signal level for detecting a workpiece. Changing the level from the standard level of 50% to a level such as 75% will enable the measurement of a transparent sheet. The measurement accuracy, however, will be degraded since measured data fluctuates according to the edge conditions of the sheet.
- It is possible to set the SHL level between 5% to 95% for "7 SHL" by setting up "7 ADD"="USE" and "7 DLC"="OFF" in the expanded basic setup.

NOTE Measuring accuracy differs from that of the standard set up.

- Measured data differs with the change of the SHL. Perform calibration again if the SHL setting has been changed.
- Measurement error can be reduced by performing calibration with the reference standard, the edges of which have been made in the same condition as those of the sheet to be measured.



IMPORTANT

- When the SHL (signal level for detecting a workpiece) is modified, the measurement accuracy will be inevitably reduced, since the measured data may easily fluctuate with the edge conditions.
- Once the SHL (signal level for detecting a workpiece) has been modified, always perform another calibration.
- If an identical edge form is selected for both for the calibration standard and workpiece (sheet), it may be possible to reduce these measurement errors.

3.2.4.2 Ultra-fine wire measurement

- In the special ultra-fine wire measuring region, a clear shade can not be obtained because a workpiece, with a finer diameter than that of the laser beam at the focal position, must be measured. Therefore, this wire diameter must be calculated according to a special algorithm. This requires the following restrictions to be taken into account in the basic setup where an ultra-fine wire measurement is designated.

  a) Measuring interval (measurement time)

  Note that the measurement time for the first measurement becomes 0.02 seconds longer than the first interval since the wire diameter must be identified at the start of ultra-fine wire measurement.

  - Single-run measurement: (Measurement interval + 0.02 seconds)
  - Continuous-run measurement: (Measurement interval + 0.02 seconds) for the first measurement, and at regular measurement intervals for the second and subsequent measurements.

  b) Number of averaging times

  Select a number between 16 and 2048.

  c) Designation of the objective portion of workpiece to be measured

  Only a segment specification is allowed, but an edge specification is not. If an edge specification has been made before the setup for the ultra-fine wire measurement is established, it is automatically changed to segment specification.

  In other cases where multiple segments are set for the LSM-500S, the minimum allowable measuring range begins at 0.1 mm. In addition, if a workpiece measures less than 0.1 mm, only one segment can be specified.

  d) Others

  In extra-fine wire measurements, simultaneous measurement, dual measurement (measurement using two measuring units), workpiece automatic detection, and group judgment can not be set up. Setups for these functions are automatically canceled.

- The measuring position is a critical factor for ultra-fine wire measurement. Always perform the measurement at the focal position of laser beam while referring to Section 5.2.2 “Displaying the measuring position”. In other cases where a fine gap is to be measured, the amount of laser light may be insufficient, resulting in unstable measurements. Refer to Section 4.4, “Recording the Amount of Light”, and store the amount of light without the workpiece and fixtures in the optical path.
- The following table shows the measuring ranges if “Not performing ultra-fine wire measurement” is designated on the LSM-500S.

Measuring range	Standard measuring range (at the factory)	Measuring range if “ Not performing ultra-fine wire measurement” is designated
LSM-500S	0.005 to 2 mm	0.1 to 2 mm

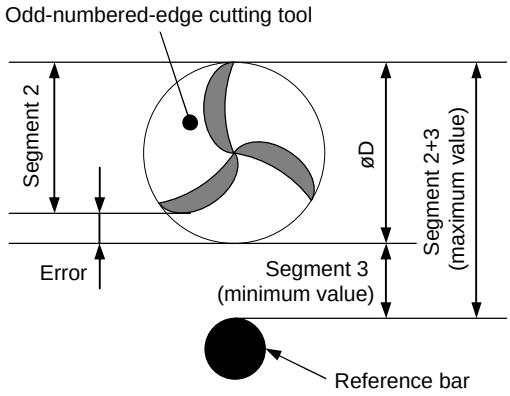
- The ultra-fine wire measurement function is only available on the LSM-500S.

IMPORTANT

1. For measuring ultra fine wire with a diameter thinner than that of the laser beam, the SHL (signal level for detecting a workpiece) needs to be changed according to the workpiece size (external diameter).
2. Since the SHL is changed to the level most appropriate for the workpiece size, multiple workpieces or workpiece fixtures existing within the laser scanning range may disable the detection of a workpiece less than 0.05 mm in diameter. Exercise care so as not to produce multiple shadows within the scanning range.
3. Also, if the segment is set to 1 or 3, it is not possible to determine the position of a fine workpiece less than 0.05 mm in diameter, runout, and bending.

3.2.5 Measurement of an odd-numbered-edge cutting tool

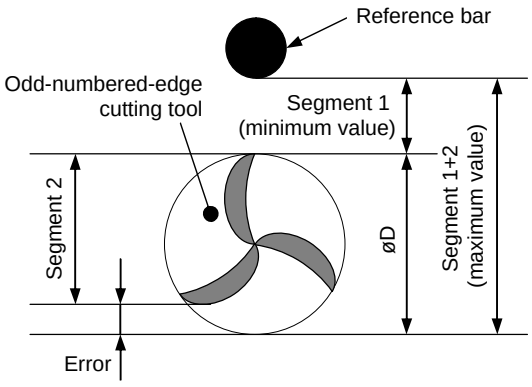
- This function is used to measure the diameter or run-out of cutting tool (drill or end mills, etc.)that has an odd number (3, 5, ...) of cutting edges.
- When the outside diameter, øD, of an odd-numbered-edge cutting tool is measured, the measurement errors as shown in the figure below will result if this LSM unit is set to Segment 2 (normal outside diameter measurement) for measurement.
  To avoid these errors, in this case, first install the reference bar as shown below, then perform the measurement while rotating the odd-numbered-edge cutting tool. Calculate the outside diameter of the odd-numbered-edge cutting tool by obtaining the difference between “Peak value of Segment 2+3” and “Bottom value of Segment 3” while the cutting tool rotates more than one turns from the beginning of measurement.
  Then save the bottom value of Segment 3 into memory as many as the number of cutting edges being set, and calculate the range (maximum - minimum) as the “run-out”.



- For the measurement examples and setup method refer to Section 5.3.6 “Application of the odd-numbered-edge cutting tool measurement”.

TIP

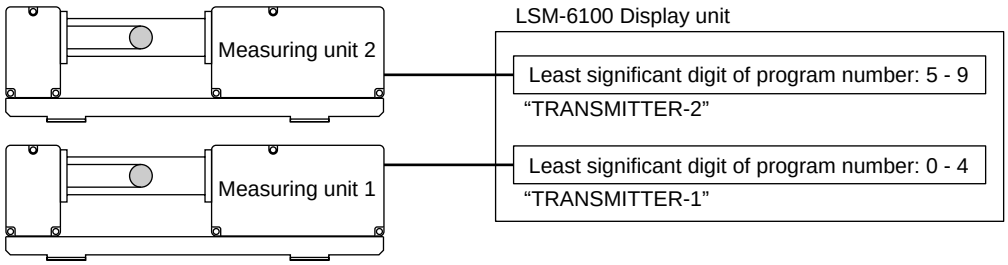
- As shown in the figure at the right it is also possible to measure with the reference bar being located in the Segment 1 side.
  In this case the “outside diameter” of the odd-numbered-edge cutting tool can be calculated by obtaining the difference between “Peak value of Segment 1+2” and “Bottom value of Segment +1” while the cutting tool rotates more than one turns from the beginning of measurement.
  Also, the “run-out” can be calculated by saving the bottom value of Segment 1 into memory as many as the number of cutting edges being set to Segment 1, and calculate the range (maximum - minimum).



- It is necessary to select, in the basic setup, whether the reference bar is located in the Segment 1 side or in the Segment 3 side.

3.2.6 Measurement with two Measuring Units (dual-unit measurement)

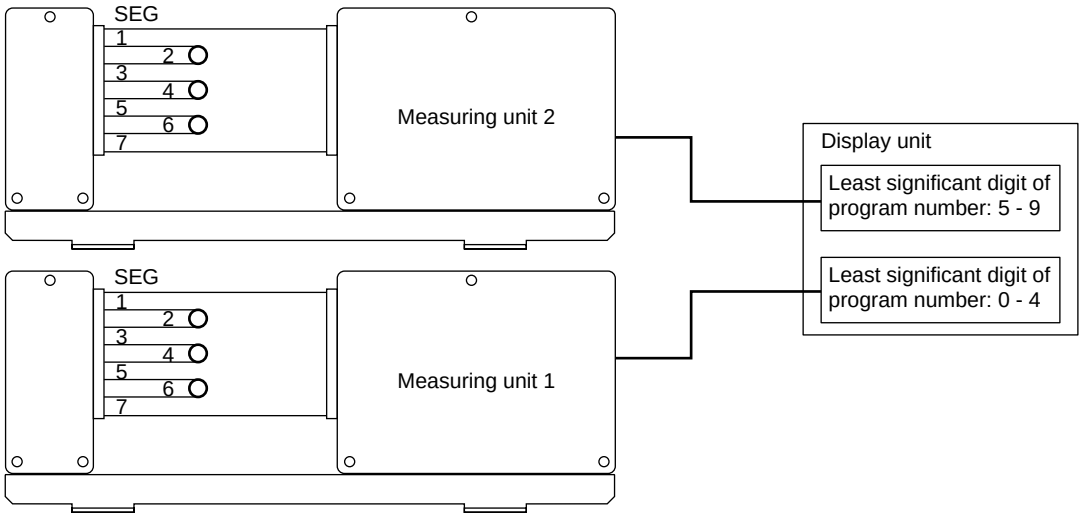
- The LSM-500S series Measuring Unit allows measurement to be performed with two Measuring Units, if the optional dual-type add-on unit is provided.
  To use two Measuring Units they must be the same model.
- About Measuring Unit 1 which is connected to “TRANSMITTER-1” side, and Measuring Unit 2 which is connected to “TRANSMITTER-2” side
  a) The W.P. (Work Position) LED shows the workpiece position of the Measuring Unit 1 when the least significant digit of program number between 0 and 4 is specified, and that of the Measuring Unit 2 when the least significant digit of program number between 5 and 9 is specified.
  b) Select he least significant digit of program number between 0 and 4 to calibrate Measuring Unit 1, and between 5 and 9 to calibrate Measuring Unit 2.



- If the dual-type add-on unit is mounted, select the type of dual-unit measurement in the basic setup.
  Note that if the type of dual-unit measurement is changed in the basic setup, calibration values and function setups will be default-set.
- If the dual-type add-on unit is not set, the setup guidance for it will not be displayed.
- Suspended use of Measuring Unit
  For repair or adjustment services one of the Measuring Units employed for dual-unit measurement may be suspended from operation. If this is the case, turn off the power and disconnect the Measuring Unit. If the Measuring Unit 1 has been disconnected, the Measuring Unit 2 must be connected to the TRANSMITTER-1 while re-installing the corresponding ID unit in place. After removal of one measuring unit, designate NONE in the basic setup (4.1.2.3 Selecting an setting the function in the B2 mode: d. Setting the dual-unit measurement).
  If one Measuring Unit is removed without this designation, “Err-8” will result and the other Measuring Unit will also become inoperable.
  Note that suspending one Measuring Unit will cause the calibration values and function setups to be reset to their defaults.
- The type of dual-unit measurement includes DW-, DXY-, and DF-types.

3.2.6.1 DW type

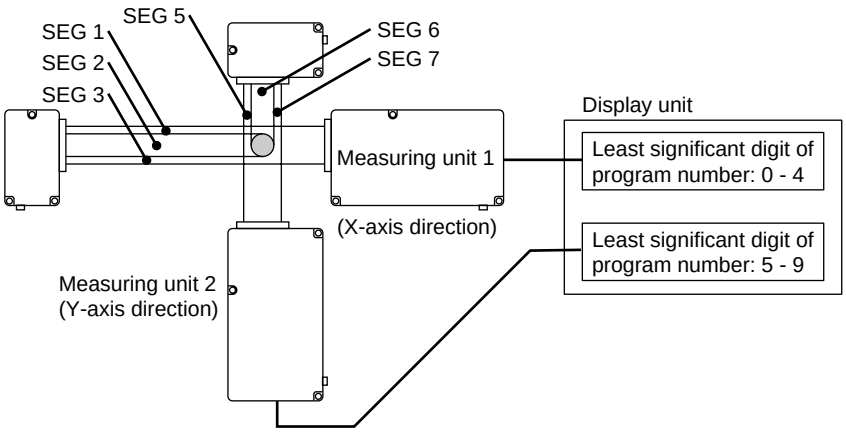
- This setting is used if two workpieces are measured by two measuring units set in parallel.
- On each of the Measuring Units 1 and 2 the measuring position can be selected from segments 1 to 7 (1 to 3 for measuring a transparent object) or edges 1 to 255.



- **Calibration**
  Select each segment for Measuring Unit 1 with the least significant digit of program number between 0 and 4, and select each segment for Measuring Unit 2 with the least significant digit of program number between 5 and 9.

3.2.6.2 DXY type

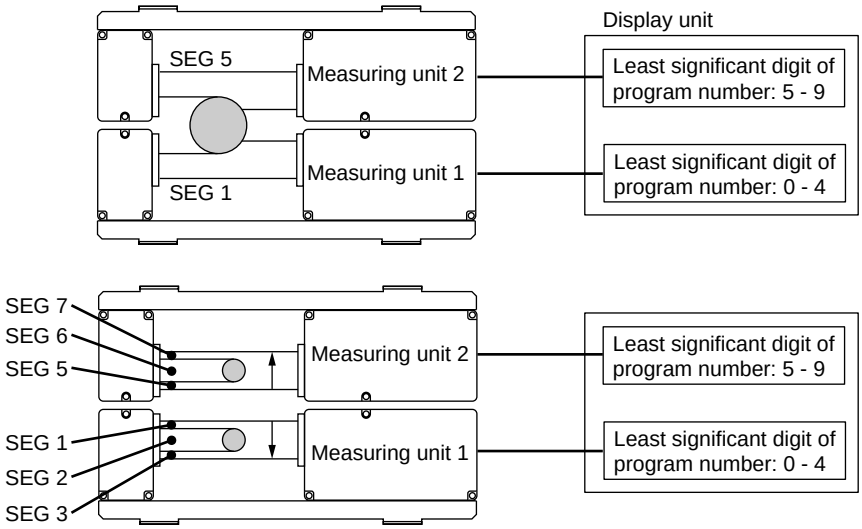
- Used to perform X-Y (2-axis) measurement with two Measuring Units positioned perpendicular to each other.
- For DXY-type measurement the objective portion of the workpiece to be measured should be selected through segment specification, not by edge specification.
  Select segments 1 to 3 for Measuring Unit 1, and select segments 5 to 7 for Measuring Unit 2.



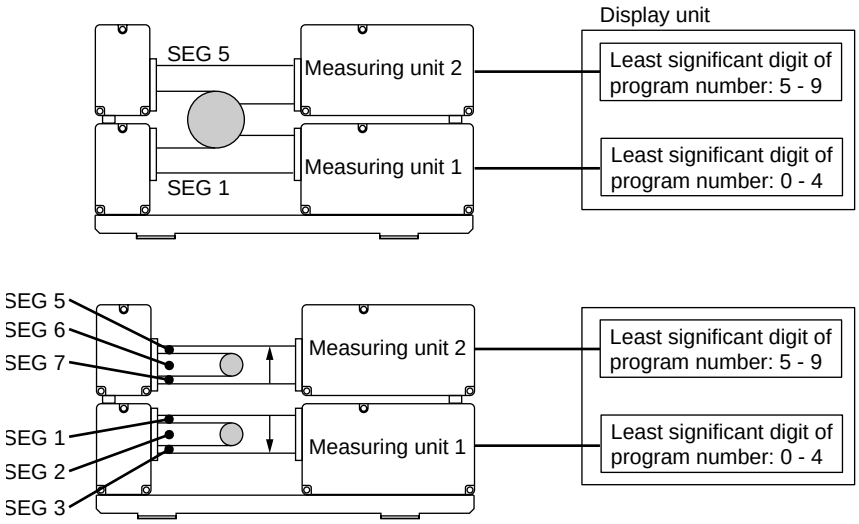
- **Calibration**
  Select each segment (between 1 and 3) for Measuring Unit 1 with the least significant digit of program number between 0 and 4, and select each segment (between 5 and 7) for Measuring Unit 2 with the least significant digit of program number between 5 and 9.
- Any program number can be assigned to segments 1 to 3 (in the X direction) and segments 5 to 7 (in the Y direction).
- If one segment for each of the X and Y directions are selected (e.g. 2 + 6), calculation is made possible between the measurements from these segments in the X and Y directions. The calculation items can be selected in the basic setup by arithmetic addition: (X + Y), mean outside diameter: (X + Y) / 2, Difference: (X-Y), and film thickness: (X-Y) /2.

3.2.6.3 DF type

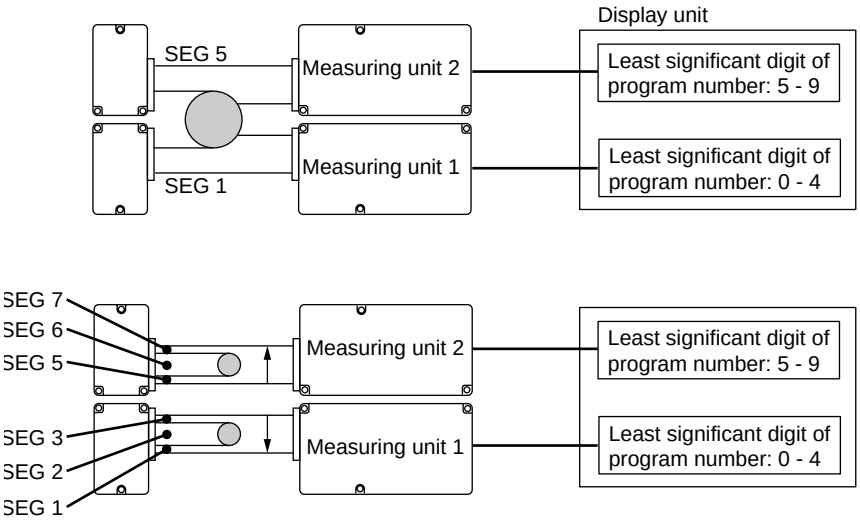
- Used to measure the diameter of a large workpiece using two Measuring Units facing each other, one stacked on top of the other, or positioned back to back.
- For DF-type measurement the objective portion of the workpiece to be measured should be selected through segment specification, not by edge specification.
  Select segments 1 to 3 for Measuring Unit 1, and select segments 5 to 7 for Measuring Unit 2.



a) Example of units facing each other



b) Example of stacked units



c) Example of units positioned back to back

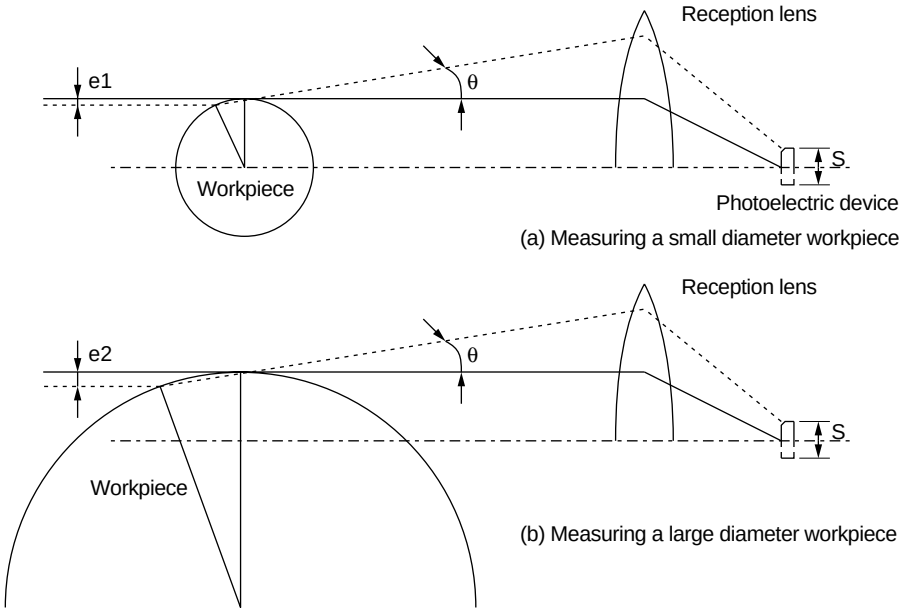
- Position two Measuring Units back to back as shown in 3) above to measure a transparent object with the DF-type setup.
  Transparent objects may not be measured with units facing each other or stacked one on top of another.
- For information about techniques to improve the measuring accuracy refer to the measuring unit user's manual.

- **Calibration and combined offset**

  a) Separate calibration for each Measuring Unit
  Perform the calibration after selecting Segment (1 ~ 3) at the Measuring Unit 1 side with the least significant digit of program number set to between 0 and 4 for Measuring Unit 1, and Segment (5 ~ 7) at the Measuring Unit 1 side with the least significant digit of program number set to between 5 and 9 for Measuring Unit 2, respectively.

  b) Combined calibration
  In addition to being able to perform separate calibration for each Measuring Unit, the DF-type setup allows the use of combined calibration where segments are assigned over two Measuring Units.
  This combined calibration is effected from either combination of segments (1 + 5) or (1 + 7).
  Note that cancellation of separate calibration will also cancel the combined calibration.

IMPORTANT Since the reflection light from a large-diameter workpiece (skip phenomenon) is generated in DF-type measurement, the accuracy decreases to some extent, compared with the linearity of each measuring unit. The following figure shows that undesired values e1 and e2 are generated due to reflected light. The undesired value (e1, e2) increases with the diameter of the workpiece (e2 > e1). This depends on the reflectivity of the surface.
Therefore, if each measuring unit is calibrated independently using a small diameter gage, an error may result if a large diameter is measured.



If a large-sized workpiece is measured using the DF-type setup, combined calibration will ensure more accurate measurment.

c) Combined preset

While combined calibration is used to measure workpieces of various sizes, the combined preset is used to measure workpieces with a dimension close to the reference gauge.

Since, at a combined preset, separate values can be set for each program number, a maximum of 100 kinds of workpieces can be registered. To perform the combined preset make the measuring positions of the reference gauge and workpiece as consistent as possible.

Designate the combined preset by combining segments such as (1 + 5) or (1 + 7), and set the direction to negative (1).

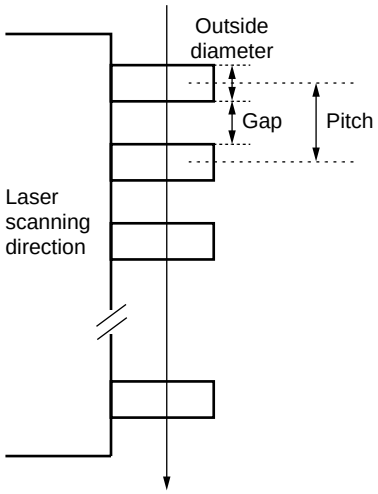
However, if this is coupled with a combined calibration, set the direction to positive (0).

3.2.7 Latch (holding) of the displayed value

- In a single-run measurement, etc., GO/NG judgment and analog output will be continued while the measured data is latched (held) on the display for the specified period of time. After the set period elapses, system operation returns to the ready state.
- Set up the display latch timer in the basic setup.
- While the display is being latched, inputs from the I/O interface or RS-232C/GP-IB are still valid.

3.2.8 Automatic measurement with an edge specification

- If the edge specification is made, it is possible to automatically measure IC or connector leads with respect to their pitch (even intervals), outside diameter, or gap. This is suitable for inspecting the IC lead bend, etc.



- This function is only in effect if the necessary setups are made for edge specification in the basic setup.
- In the function setup designate whether automatic measurement should be performed (for pitch/outside diameter/gap measurement) or not (manual measurement). Also designate both the start and finish edges.
- This is available in combination with automatic workpiece detection.
- If automatic measurement has also been selected, the following will take place.

  a) In the ready state the first objective portion of the workpiece to be measured will be displayed.

  b) Automatic measurement will be involved in a single-run measurement or continuous-run measurement.
  If “Err-0” (insufficient number of edges to be measured) is detected, the measuring operation is stopped for the single-run measurement, and the collected measured data is cleared for continuous measurement to wait for a proper workpiece to be loaded.

  c) If the measured data is found to be ±NG, the first source of the ±NG will be displayed and the measuring operation is stopped. If GO results, the mean of all measurements is displayed.

  d) If the measured data falls within the range of GO, the elapsed measurement time was as follows:
  (Number of measurement edges) x (measurement interval) + (calculation time: 20 ms)

  e) The W.P. LED shows the current portion of the workpiece being measured.

3.2.9 GO/NG judgment

- All the measured data are subject to GO/NG judgment.
  To enable, set the GO/NG judgment criteria in advance.
- The following settings can be made in the basic setup.

  a) The method of tolerance judgment can be selected from (Lower limit value and upper limit value), multi-limit selection (7 limits) and (Target value and tolerance values: upper tolerance value and lower tolerance value).
  To output the judgment result with the multi-limit selection it is necessary to select the optional Second Analog I/O Interface.

  b) Simultaneous measurement can be specified. To do this, it is necessary to select the optional Second Analog I/O Interface for tolerance result output.

  c) For (Target value and tolerance values), the user is permitted to select whether the target value is to be copied to the reference value. If it is, the setup guidance for the reference value will not appear.

  d) Even in the ready state it is possible to select whether tolerance judgment and analog output are performed. If they are, tolerance judgment and analog output will take place in the ready state, however, these data are not available for statistical processing.

  e) Abnormal data elimination, tolerance judgment, group judgment, and analog output can be performed in a single-run measurement, zero-run measurement, sample measurement, and continuous-run measurement (with a term specification). The judgment result will be indicated by the -NG (red LED), GO (green LED), and +NG (red LED) indicators and outputted to the I/O interface and RS-232C (including printer)/GP-IB interface.

  f) The following tables show the relationship between the measured data and tolerance judgment method

  1) (Lower and upper limit values)

GO/NG judgment	Measurement (judged if both the lower and upper limit values are set)
-NG	Measurement < Lower limit value
GO	Lower limit value ≤ Measurement < Upper limit value
+NG	Measurement ≥ Upper limit value

  2) (Target value and tolerance values)

GO/NG judgment	Measurement (judged if the target value, lower tolerance value and upper tolerance value are set)
-NG	Measurement < (Target value + lower tolerance limit)
GO	(Target value + lower tolerance value) ≤ Measurement < (Target value + upper tolerance value)
+NG	Measurement ≥ (Target value + upper tolerance value)

3) If all limits from L1 to L6 are set for multi-limit selection

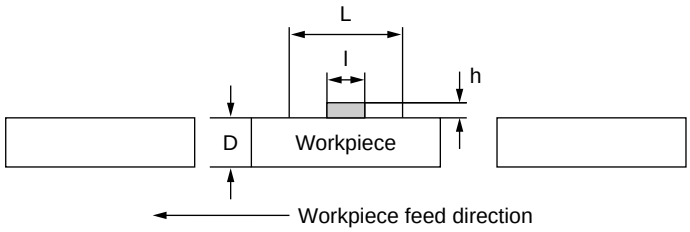
Multi-limit selection output	GO/NG judgment	Measurement from L1 to L6 are set.
L1	-NG	Measurement < L1
L2	GO	L1 ≤ Measurement < L2
L3	GO	L2 ≤ Measurement < L3
L4	GO	L3 ≤ Measurement < L4
L5	GO	L4 ≤ Measurement < L5
L6	GO	L5 ≤ Measurement < L6
L7	+NG	L6 ≤ Measurement

4) If only L1 and L2 are set for multi-limit selection

Multi-limit selection output	GO/NG judgment	Measurement Only L1 and L2 are set. (Judgment will not be performed if only one stage is set.)
L1	-NG	Measurement < L1
L2	GO	L1 ≤ Measurement < L2
L3 ~ L7	+NG	L2 ≤ Measurement

3.2.10 Abnormal data elimination

- The abnormal data elimination function eliminates measurements that are very different from those specified for the machined workpiece, from the measurement data (neither the measurement is displayed nor is data output performed).
  If, for example, the grindstone of a centerless grinder is controlled based on the measured data from the LSM, it is possible that a large measurement error may be created due to the coolant used with the workpiece.
  As shown in the figure below where foreign matter (with a height of h) adheres to within the averaging region L of the workpiece (with a diameter of D). An abnormal outside diameter results in the region of l and the displayed measurement will be (D + lh / L). As the result the grinder is subject to improper control that involves some error.



  Because the use of this function can eliminate abnormal measurement data generated due to the adhered foreign matter, the grindstone can be controlled and fed properly.

- Judgment of valid data or abnormal data will be performed at each measurement interval. Valid data includes those satisfy the following relation: Lower abnormal limit ≤ (Measurement) < Upper abnormal limit. All other data will be discarded as abnormal data.

- The following table shows the relationship between measurements and upper and lower abnormal limits.

Eliminate/Do not eliminate	Measurement (Judged if both the upper and lower abnormal limits are set.)
Eliminate	Measurement < Lower abnormal limit
Do not eliminate (accepted as a measurement)	Lower abnormal limit ≤ Measurement < Upper abnormal limit
Eliminate	Measurement ≥ Upper abnormal limit

- In the basic setup select whether this abnormal data elimination function should be used. If it is the setting of (lower abnormal limit, upper abnormal limit, and count value) should be performed before actual tolerance judgment.
  This count value indicates the number of pieces of abnormal data that occurred until the alarm will be issued. This alarm output will be sent to the optional Second Analog I/O Interface by $\overline{\text{CNT}}$ form (The alarm will not be issued if the count value is set to zero).

- Abnormal data elimination function effects in single-run and continuous-run measurements.

- If “Err-0” (specified workpiece not present) is displayed in the sample measurement, the valid data collected will be discarded.

NOTE If a long series of abnormal data appears, measurement can no longer be continued since most of the measured data must be eliminated. To avoid this problem, always monitor CNT output.

3.2.11 Preset/Zero-set

This function is used to measure the difference between the workpiece and the reference gage or to measure the workpiece that is larger than the measuring range of the LSM.

a) Preset

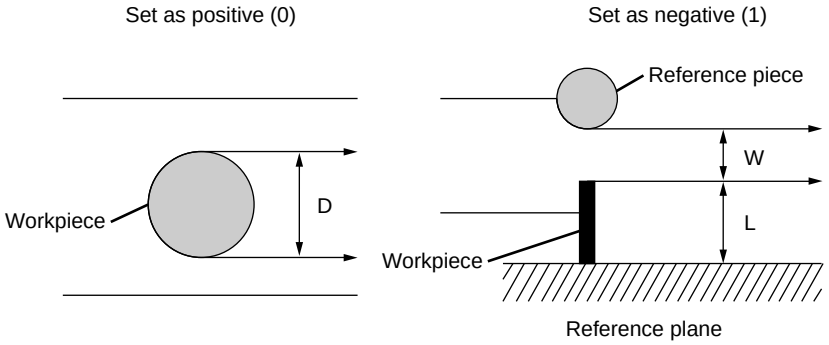
- In this system the operation of setting the reference gage dimension is called the preset operation.
- This function is applied to measure the absolute dimension of a workpiece.

b) Zero-set

- Setting the reference gage dimension to "0.0" for the purpose of comparing it with a workpiece dimension is called the zero-set.
- This function is applied to measure a deviation from the reference gage dimension.

c) Direction

Depending on the objective portion of measurement of a workpiece, the positive direction (set as "0") or negative direction (set as "1") must be set.
If, for example, the shaded portion of D in the following diagram is measured, the direction must be set as positive (0). If the highlighted portion (gap) of W is to be measured for determining the workpiece dimension L, the direction must be specified as negative (1).



- Preset operation takes about 1 second to determine the compensation value by measuring the reference gage.
- Preset value will be ineffective if the segment or edge number is changed (Preset value is unique to each segment or edge).

3.2.12 Mastering

- If the objective workpieces are high-precision gages that are machined successively, the above described preset/zero-set values may need to be fine-adjusted to the master. This fine-adjustment is called mastering.
  After mastering, the total compensation value will be:
  (Preset value/zero-set value) + (±Mastering value)
  Setting a positive (+) mastering value allows the measurement of a workpiece OD to be greater than the raw measurement, and setting a negative (-) mastering value allows the measurement of a workpiece OD to be smaller than the raw measurement.
- Because no measurement is required for this mastering, the reference gauge is not required either.
- Set the reference gage dimension with the preset function and perform mastering.

3.2.13 Reference value

- This function is used to output deviations (measured data - reference value) between the reference value and the actual measurements of a workpiece for the Analog I/O Interface. Before analog output, set the reference value and the scale value (gain).
- Measured data is outputted as analog signals at a full scale of ±5V.
  Analog signal = (Measured data - reference value) x scale value (gain)
- In the basic setup the following conditions can be set.
  a) Whether the target value of GO/NG judgment is be copied to the reference value. If this is selected, the setup guidance for the reference value will not be displayed, so only the scale value must be set.
  b) It is also possible to set so that tolerance judgment and analog output can take place in the ready state.
- Analog output is automatically enabled if single-run measurement or continuous-run measurement is performed.
- If the reference value is being set the deviation value will be output for the RS-232C/GP-IB interface and the printer if single-run measurement or continuous-run measurement is performed.

3.2.14 Data output conditions

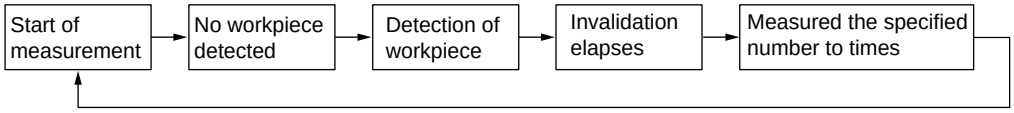
- In single-run measurement or continuous-run measurement, measured data can be outputted for each measurement if ±NG occurs, or at given intervals to the RS-232C/GP-IB interface, printer, or Mitutoyo Digimatic Output Unit.

Data output condition	RS-232C GP-IB DCU	Printer	Remark
0			
1		○	The periodical output timer can be set
2		△	
3	○		The periodical output timer can be set
4	△		
5	○	○	The periodical output timer can be set
6	△	△	
7		□	
8	□		
9	□	□	

○ : Outputted for each measurement if DATA C/RUN or C.RUN key, etc., is pressed.
△ : Press the DATA C/RUN or C.RUN key to trigger the measurement. The measured data will be outputted if it falls on GO.
□ : Press the DATA C/RUN or C.RUN key to trigger the measurement. The measured data will be outputted if it falls on –NG.
: No output will be made.

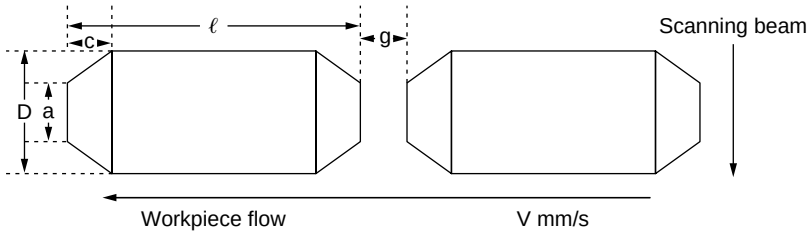
3.2.15 Automatic workpiece detection <OD detection method, Position detection method>

- Automatic workpiece detection is performed for continuous-run measurement, where measurement starts with no specified workpiece present (Err-0), then proceeds to automatic detection of the workpiece, followed by measurement repeated number of times. No specified workpiece present (Err-5) also refers to the workpiece outside the upper and lower detection limits.
- Whether automatic workpiece detection is performed is specified in the basic setup mode. If automatic workpiece detection is specified, the number of scanning times for detection must be specified from among 1 and 16. Select 16 times if detecting precision workpieces. If automatic workpiece detection is not specified, no further setting is necessary.
- Automatic workpiece detection setup includes the number of measurement times, invalidation period, upper and lower detection limits. Set both the upper and lower detection limits.
- To exclude the measured data of such as chamfered portion of the workpiece, invalidation period can be set within the range from 0.001 sec to 9.999 sec.



1) OD detection method

- This is used to automatically detect a workpiece that enters the laser scanning plane perpendicularly.
- For actual detection of a workpiece the displayed measurement (after calibration and preset) is used.
- One session of automatic detection consists of no workpiece being detected, detection of a workpiece with a dimension that is within the detection range (between the upper and lower detection limits), an invalidation period required to exclude invalid dimensions (of chamfered portions, etc.) from the measurement, and effective measurement for the specified number of times. The final measurement result will be latched (held) on the display. Once entering the effective measurement the upper and lower detection limits will no longer be checked.
- The speed of workpiece detection (i.e. the number of scans) can be specified as either 1 or 16 in the basic setup.
- Use 16 times in the following cases:
  * If connecting bars are used between workpieces for feeding convenience and for setting appropriate intervals between workpieces, and, if the difference in the outside diameter between the workpiece and the bar is insufficient.
  * If the feed rate is low.
- The following diagram is an example where a workpiece with a chamfered outside diameter of D mm and a length of ℓ mm moves at a velocity of V mm/s.

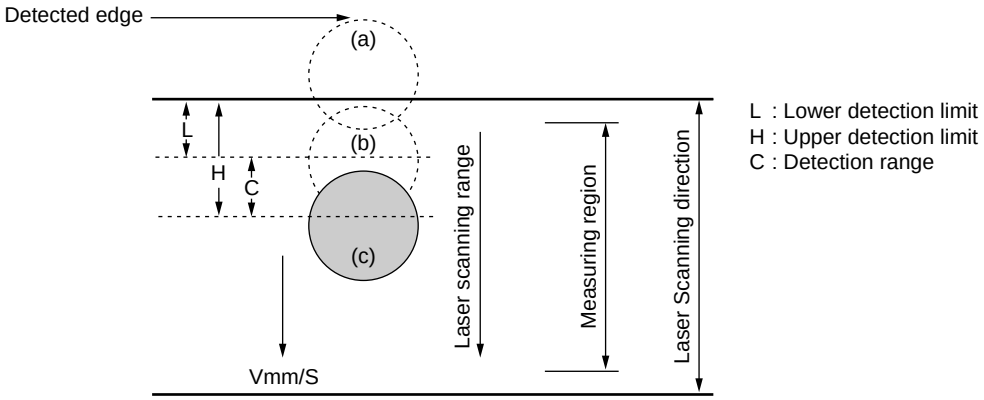


Setting example:

- Lower detection limit: L < (a +D) / 2
- Upper detection limit: H > Upper limit of the measuring range or 1.1 D
  (This setting may be omitted.)
- Invalidation period : T > (c / V) ms
- Number of measurements: N < (ℓ - 2c) x 0.8 (safety factor) / measurement interval / V

2) Position detection method

- This is used to automatically detect a workpiece that enters the measuring region in the laser scanning plane in the same direction of the scan.
- Workpiece detection is performed with one scan, and 16 scans can not be specified (If specified in the basic setup, the specification will be ignored).
- One session of automatic detection consists of the detection of no workpiece, detection of a workpiece edge with a dimension that falls within the detection range (between the upper and lower detection limits), an invalidation period required to exclude invalid dimensions from the measurement, and effective measurement for the specified number of times. Once the effective measurement has been entered, the upper and lower detection limits will no longer be checked.
- In the following diagram, workpiece positions (a) and (b) result in no workpiece being present, and in (c) it is judged that a workpiece is present.



Setting example:

Assuming the workpiece diameter as D (mm) and the moving speed as V (mm/s):

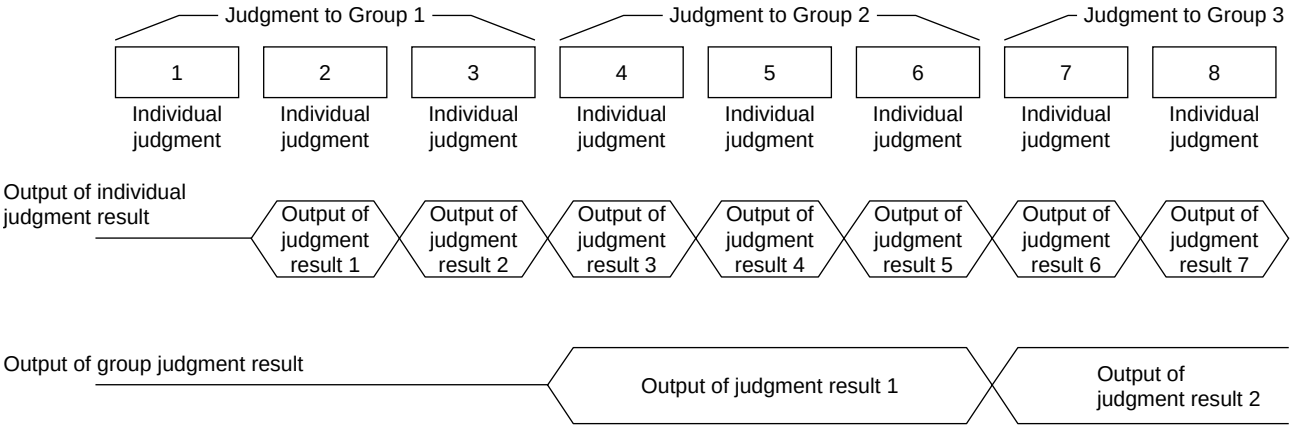
- Lower detection limit: L > (Laser scanning range - measuring region) / 2
- Upper detection limit: H < (Laser scanning range + measuring region) / 2 - D (This setting may be omitted.)
- Invalidation period : Generally set to 0 ms.
- Number of measurements: N = 1

NOTE

- Allow a sufficient margin for the lower detection limit, upper detection limit, invalidation period, and number of measuring times when setting them. If this surplus is not sufficient, the measurement may not be achieved.
- If using the sample measurement, specify the number of measuring times to 1.
- The automatic workpiece detection functions in the continuous-run measurement.

3.2.16 Group judgment

- While the tolerance judgment is applied to each measurement from a workpiece, this group judgment is applied to a group of the specified number of workpieces.



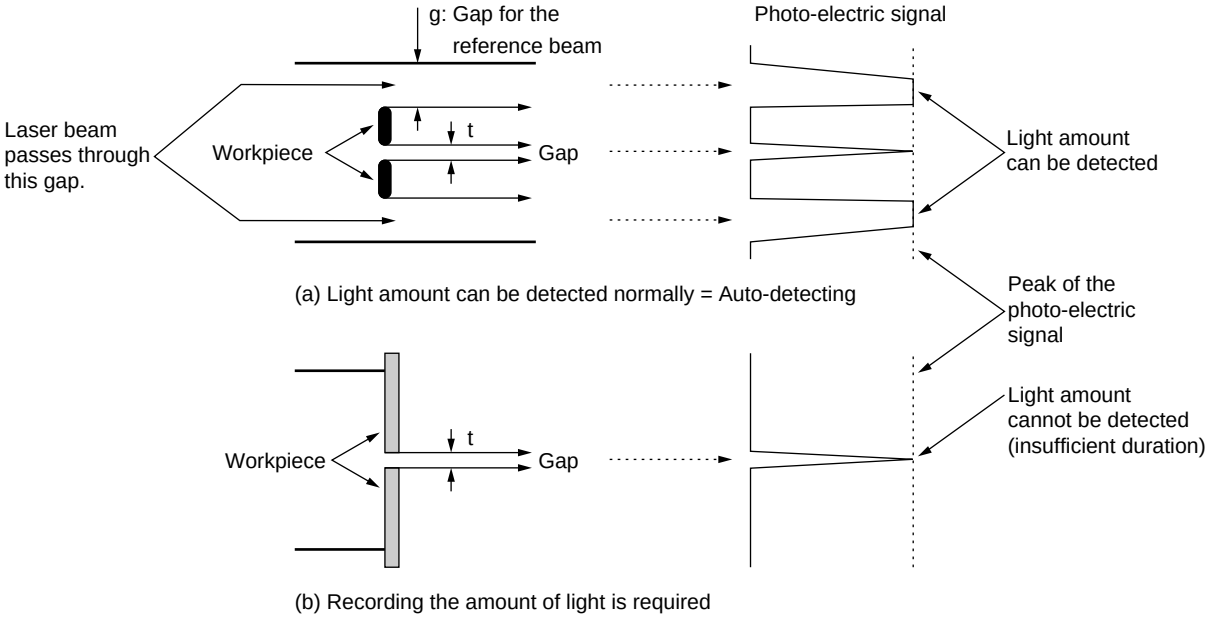
- In the basic setup select whether group judgment is to be performed. If it is, then set the group size (the number of workpieces included in a group), calculation items (mean, maximum value, minimum value, and range), and group lower limit and upper limit. If "Not performing group judgment" is selected, the setup guidance for it will not be displayed.
- The group judgment will be in effect in a single-run measurement or continuous-run measurement.
  a) For the result display and GO/NG judgment indication each individual measurement and judgment result will be used.
  b) Output of judgment result
     1. If only the standard Analog I/O Interface is used
        Each individual judgment result will be outputted.
     2. If the second Analog I/O Interface is used
        Each individual judgment result will be outputted for A-(+NG), A-(GO), and A-(-NG), and the group judgment result will be outputted for B-(+NG), B-(GO), and B-(-NG), respectively.
  c) RS-232C/GP-IB output
     In the basic setup it is possible to set whether the group judgment result data is outputted for the RS-232C/GP-IB interface. If it is, the output contents from the group judgment will be as follows:

```
P0,    ( GO)   12.34567 ... Individual data
P0,    ( GO)   12.34560 ... Individual data
P0,    (+NG)   12.34600 ... Individual data
GP0,   ( GO)   12.34575 ... Group judgment result data
```

- Each individual piece of measurement data can be the objective of statistical processing, however, group measurement data will be excluded from statistical processing.
- Even if "Err-0" (specified workpiece not present) occurs, the obtained data will not be cleared. To abort the measurement, press the [C] key (or input $\overline{\text{RESET}}$ via the I/O Interface or the "CL" command via the RS-232C/GP-IB interface).

3.2.17 Recording the amount of light

- The gap measurement may be unstable if not enough laser beam passes through the gaps. In the case shown in diagram (a) below, an adequate amount of light can be obtained as the laser passes through gap (g) above the workpiece, even if the gap (t) is small. However, in diagram (b) where gap (t) is small, measurement will be affected. In this case, therefore, it is necessary to have the system record the full amount of light when there is no obstruction (workpiece or fixture) in the optical path.



(a) Light amount can be detected normally = Auto-detecting

(b) Recording the amount of light is required

- Normally the amount of incident light is continuously checked so that the counting operation can follow the change in the amount of incident light. Have the system record the light amount following 4.4, “Recording the light amount”. It is also necessary to carry out this operation twice or three times each year since the light amount of the system may vary.
- If the amount of light is recorded, temperature drift of the measured data becomes larger.
- The minimum size of gap (t) that can be measured depends on each Measuring Unit as shown below:

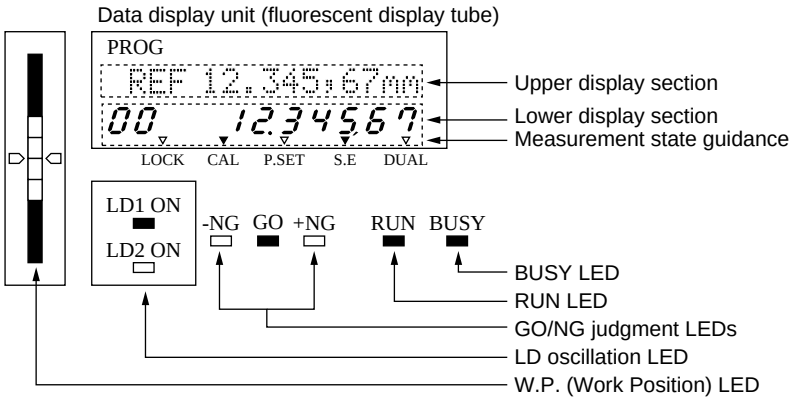
Model name	Gap: g or t
LSM-500S	0.2 mm or more
LSM-501S	0.3 mm or more
LSM-503S	1 mm or more
LSM-506S	2 mm or more
LSM-512S	4 mm or more
LSM-516S	6 mm or more

3.3 Outline of the Display Contents

Displays of this system are effected by the display unit and guidance LEDs.

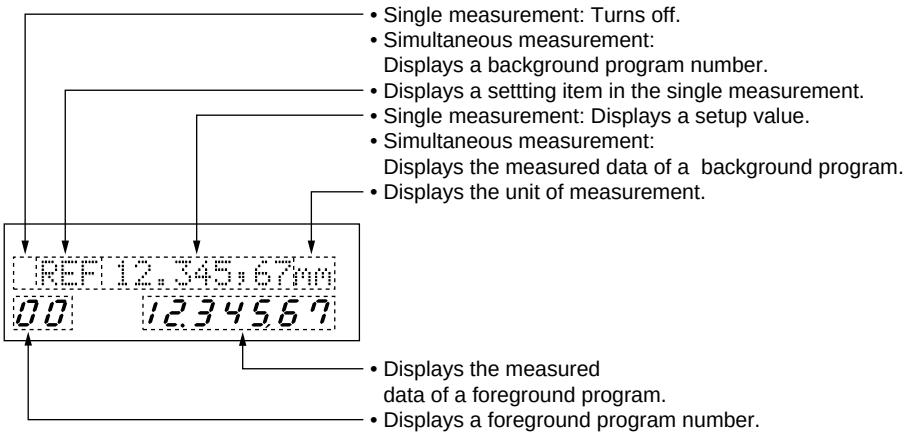
3.3.1 Display unit

The name of each part of the display unit and the LEDs are given below:



3.3.2 Data display unit

1) Numeric and character display



2) Operation state guidance

- LOCK: Turns on in the key lock state, which is initiated by pressing both the SHIFT and LOCK/UNIT keys. If these keys are input the key lock state will be canceled.
- CAL: Turns on if the calibration (HIGH) is specified.
- P.SET: Turns on if the preset function is active.
- S.E: Turns on if statistical processing is activated.
- DUAL: Turns on if simultaneous measurement is specified.

3) Display LED

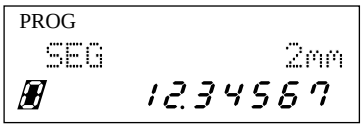
- W.P. (Work Position) LED
  LED segments corresponding to a region shaded by the workpiece, which blocks the laser beam, will turn off. This is used to check if the workpiece is located in the center of the measuring region.
- LD oscillation LED
  1. LD1 ON : Indicates that the laser in the Measuring Unit connected to the "TRANSMITTER-1" connector is oscillating. If a dual-unit measurement is not performed (standard specification), only this LED lights and the LD2 LED is off.
  2. LD2 ON : Indicates that the laser in the Measuring Unit connected to the "TRANSMITTER-2" connector is oscillating. This LED also lights for a dual-unit measurement.
- GO/NG judgment LED
  1. -NG : Turns on if the measured data is -NG.
  2. GO : Turns on if the measured data is GO.
  3. +NG : Turns on if the measured data is +NG.
- RUN LED
  Turns on if a single-run measurement, continuous-run measurement or continuous-run measurement with a term specification is performed.
- BUSY LED
  Turns on each time the measured data is updated.

IMPORTANT Laser safety
For safety, the laser will not turn on until 5 seconds after the power is turned on. If the power is unintentionally turned on, turn off the power within 5 seconds to secure the laser.

3.4 Outline of Key Operations

On this system operate the keys as follows.

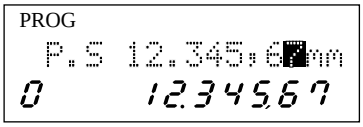
- The [STAT/S.E] key, for example, has two functions as indicated on the upper and lower portions of the key top. The function on the upper portion can be activated by simply pressing the key, and the one on the lower portion can be activated by pressing the key while holding down the [SHIFT] key. If the [SHIFT] key is pressed, the currently displayed program number flashes for about 10 seconds until another key is pressed. During this period one of the functions in the upper portions of the keys can be selected. Press the [STAT/S.E] key while the program number is flashing.



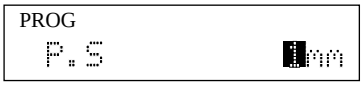
- To enter the reference gage values, such as HIGH CAL, LOW CAL and preset, or other setup values such as reference values and GO/NG judgment criteria, etc., the numeric keys ([0] to [9], [.], [+/-]) and arrow keys ([<], [>], [∧] and [∨]) can be used.

a) If a setup value entry is started with a numeric key and an arrow key is pressed halfway, an operation error will result. The following example shows a case of an preset value.

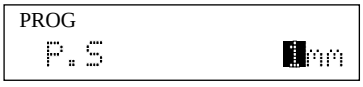
1. Enter the setup mode of the preset function.
   The least significant digit of the existing preset value is flashing.



2. Change the value to 12.00 mm.
   Press the [1] key.



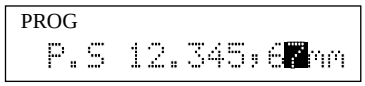
3. If an arrow key is pressed at this point, an operation error occurs, however the display does not change.



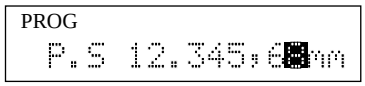
4. To enable the entry of an arrow key, press the [C] key to cancel the setup value.
   Now the arrow keys are operable.

b) If a measurement is read as the setup data by pressing the READ key or if the entry of a setup value is started with an arrow key and a numeric key is pressed halfway an operation error will result. See the example above.

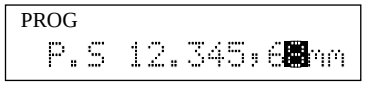
1. Enter the setup mode of the offset function.
   The least significant digit of the existing offset value flashes.



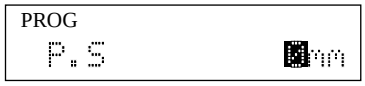
2. Enter the ∧ key.



3. If a numeric key is pressed at this point, an operation error occurs, however the display does not change.



4. To enable the entry of a numeric key, press the C key to cancel the setup value.
   Now the numeric keys are operable.



3.4.1 Description of key functions

Key name	• In the ready state • In the display-latched state	• At single-run measurement • At continuous-run measurement	• At setup • Combined use with power-on operation
0 ~ 9	• Changes the program number	• Operation error	• Enters the setup data.
•	• Operation error	• Operation error	• Enters a decimal point.
+/-	• Operation error	• Operation error	• Inverts the sign of the setup value.
C	• Cancels the error that occurred when the power was turned on. • Cancels the latched state and returns to the ready state.	• Aborts the measurement and returns to the ready state.	• Cancels the setup value or resets it to initial value. • Cancels the error state. • C + power-on will enter the initialization mode of the Display Unit.
SHIFT	• Shift key To enter the function indicated in the upper portion of a double-function key, such as the STAT S.E key, hold down the SHIFT before pressing the key. • A foreground program number will flash for about 10 seconds.	• Operation error	• Entry of SHIFT + READ (to set the light amount detecting function) is valid when the function setup item number flashes in the function setup mode.
DATA C RUN	• Performs single-run measurement (even in the display-latched state).	• Results in a single-run measurement error. • Quits the measuring operation for continuous-run measurement.	• Operation error
SHIFT DATA C RUN	• Enters in the mode to cancel the previous measurement result. • To accept the cancellation and returnto the standby state, press the ENT key while “CANCEL” is blinking in the upper display section.	• Operation error	• Operation error
C.RUN	• Starts continuous-run measurement (even in the display-latched state).	• Quits the measuring operation for continuous-run measurement (same as DATA C RUN).	• Operation error
S.PR PRINT	• Prints out the previous measurement data. • Prints out the data currently displayed in the display-latched state.	• Results in a single-run measurement error. • Prints out the previous measurement data in continuous-run measurement.	• Operation error
SHIFT S.PR PRINT	• If the printer is active, prints out all the statistical processing data and clears the statistical memory. • If the printer is not active, results in an operation error.	• Operation error	• Operation error

Key name	• In the ready state • In the display-latched state	• At single-run measurement • At continuous-run measurement	• At setup • Combined use with power-on operation
SET	• Enters the function setup mode.	• Operation error	• Exits from the function setup mode and returns to the ready state. • Enters the state that is entered just after the power is turned on, if in the basic setup mode. • SET + power-on is used to enter the basic setup mode.
LIMIT	• Directly enters the setup mode for GO/NG judgment.	• Operation error	• Press ENT to complete the setup operation and return to the ready state. • Press LIMIT or SET to abort the setup operation and return to the ready state.
P.S V P.SET	• Performs zero-setting (in the positive direction) if an preset value is not set. • If an preset value is set, executes the preset function with the preset value being set.	• Operation error	• Operation error
SHIFT MASTER REF	• Directly enters the setup for mastering.	• Operation error	• Press ENT to complete the setup operation and return to the ready state. • Press MASTER REF or SET to abort the setup operation and return to the ready state.
MASTER REF	• Directly enters the setup operation for the reference value and scale value. • If "Copying the target value to the reference value" is specified in the basic setup, only the setup operation for the scale value takes place.	• Operation error	• Press ENT to complete the setup operation and return to the ready state. • Press MASTER REF or SET to abort the setup operation and return to the ready state.
SHIFT P.S V P.SET	• Preset can be set. • Pressing the C and ENT keys clear Preset/Zero-set.	• Operation error	• Operation error
ENT	• Operation error	• Operation error	• Accepts the setup data that is pressed.

Key name	• In the ready state • In the display-latched state	• At single-run measurement • At continuous-run measurement	• At setup • Combined use with power-on operation
STAT S.E	• Enables/disables statistical processing. • If statistical processing is active, measurement state guidance (▼) for statistical processing turns on.	• Operation error	• Operation error
SHIFT STAT S.E	• Enters the statistic display mode and displays N in the statistical memory. • Each time the ENT key is pressed S.D, MAX, MIN, AVG, R, and N are sequentially displayed. • Press STAT S.E or SET to restore the ready state.	• Operation error	• Operation error
A.CL M.CL	• Enters the clear mode of the statistical memory for the specified program number. • Press ENT to execute clear, and pressing A.CL M.CL or SET to abort the clearing operation and return to the ready state.	• Operation error	• Operation error
SHIFT A.CL M.CL	• Enters the clear mode of the statistical memory for all program numbers. • Press ENT to execute clear, and press A.CL M.CL or SET to abort the clearing operation and return to the ready state.	• Operation error	• Operation error
LOCK UNIT	• Enters the unit change mode. • Press ENT to execute a change of units, and press LOCK UNIT or SET to abort the unit change operation and returns to the ready state.	• Operation error	• Operation error
SHIFT LOCK UNIT	• Enters the key lock mode, turns on the measurement state guidance (▼) for the key lock function, then prohibits subsequent key inputs. • If these keys are pressed again in the key lock state, it will be canceled.	• Operation error	• Operation error

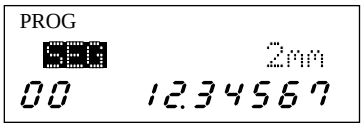
Key name	• In the ready state • In the display-latched state	• At single-run measurement • At continuous-run measurement	• At setup • Combined use with power-on operation
H.CAL	• Enters the HIGH CAL setup mode.	• Operation error	• (Input of gage diameter) + ENT executes HI CAL and illuminates the measurement state guidance (▼) for CAL. • Press H.CAL or SET in the HI CAL setup mode to abort the setup operation and return to the ready state.
L.CAL	• Enters the LOW CAL setup mode.	• Operation error	• (Input of gage diameter) + ENT executes LOW CAL. • Press L.CAL or SET in the LOW CAL setup mode to abort the setup operation and return to the ready state.
READ	• Operation error	• Operation error	• Reads the measurement of the reference gage as the setup value. • The read value can be modified with the < , > , ∧ , and ∨ keys.
SHIFT READ	• Enters the detection mode of the measurement position (focal position). • Press READ or SET to restore the ready state.	• Operation error	• If this entry is made when the function setup item number is flashing in the function setup mode, which was accessed by the SET key, the setup operation for the light amount detection is entered.
<	• This is used to enter the setup mode for the setup item that is being displayed in the upper section of the display unit.	• Operation error	• Move left key
>	• Operation error	• Operation error	• Move right key
∧	• Operation error	• Operation error	• Up key to increment the setup value.
∨	• Operation error	• Operation error	• Down key to decrement the setup value.

3.4.2 Example key operations

As an example operation this section uses an update of the tolerance limits which are displayed in the upper display section while in the ready state. Suppose that the new lower tolerance limit is “12.34500” and the upper tolerance limit is “12.34600” and that the current values are “12.00000” and “12.00100”.

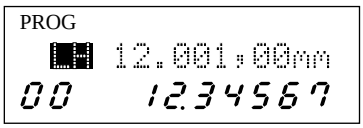
In the example below, we start with canceling existing upper and lower tolerance limits since the lower tolerance limit to be set is smaller than the existing upper tolerance limit. If this is the case, setting the lower tolerance limit first causes an error (ERR-5).

Step 1: In the ready state press the [<] key to make the setup item being displayed flash in the upper display section.

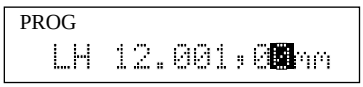


Each time the [∧] key is pressed, while the setup item is flashing, the setup item will change sequentially: Segment → Measurement interval → Lower limit value → Upper limit value → Reference value → Preset → Mastering →
If the [∨] key is pressed, the setup item will change in the reverse order.
As the displayed setup items vary with the results of the basic setup, refer to Section 5.1.1, “Settings made in the measurement mode”

Step 2: If the upper limit value is going to be canceled, make the guidance flash.



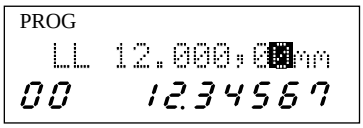
Step 3: Press either the [ENT] or [<] key to make the least significant digit of the setup data flash.



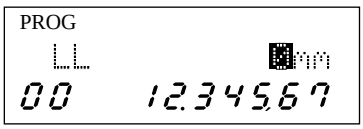
Step 4: To cancel the upper limit value press the [C] key to set the setup data to “0”.

Step 5: If the [ENT] key is pressed, the upper limit value is canceled and system operation returns to the ready state.

Step 6: After making the guidance flash by pressing the [<] key, press the [∨] and [ENT] keys to enter the setup mode for the lower limit value.



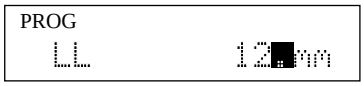
Step 7: Press the [C] key to set the display of the lower limit value to “0” (can be omitted), then enter a new lower limit value of “12.34500”.



1) Each time the numeric key is pressed the corresponding digit will be placed in the position of the least significant digit, as shown in the figure on the right. In this example insignificant zeros (0 0) are not entered, they will be automatically added to fill the remaining digit places when the ENT key is pressed.

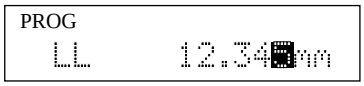
1


2

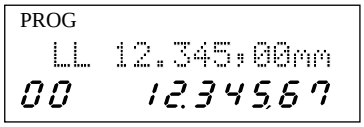

.


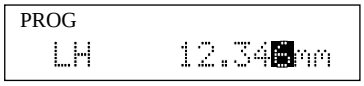
3

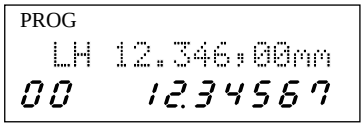

↓

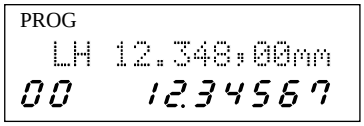
4 5


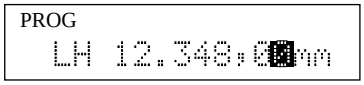
2) Press the ENT key to save the setup data of the lower limit value, and return to the ready state.
If "Inserting a comma (,) after the thousandth digit" is specified in the basic setup, it will be automatically inserted when the ENT key is pressed.

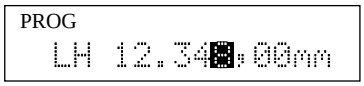
ENT


Step 8: As in steps 6 and 7, enter a new upper limit value.


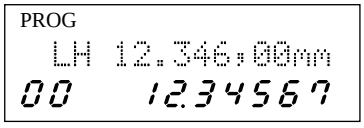
Step 9: If the ENT key is pressed, the setup data of the upper limit value is saved in memory, then operation returns to the ready state.


Step 10: Here, for practice, intentionally enter the incorrect upper limit value of "12.34800" then correct it.


Step 11: Enter the setup mode for the upper limit value again.


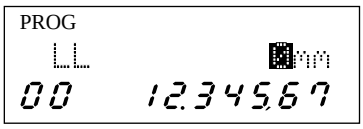
1) Press the < key twice to make the third digit flash.


2) Press the ∨ key twice to change the third digit to "6".

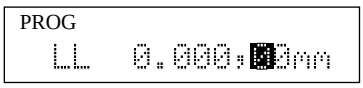

3) Press the ENT key to save the setup data. The operation will be automatically return to the ready state.


The following describes how to use the arrow keys using step 7 as an example.

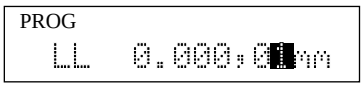
1) Now, the setup data of "0" is displayed as a result of having pressed the [C] key.



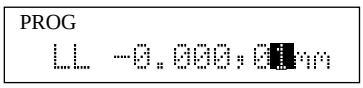
2) If the [<] key is pressed, the digit places are automatically filled with zeros to reflect the set resolution, with the appropriate number of commas inserted after the thousandth digit, then the highlighted digit moves one position to the left.



If the [∧] key is pressed, the digit places are automatically filled with zeros to reflect the set resolution, with the appropriate number of commas inserted after the thousandth digit, then the least significant digit increases by one.



If the [∨] key is pressed, the digit places are automatically filled with zeros to reflect the set resolution, with the appropriate number of commas inserted after the thousandth digit, then the least significant digit decreases by one, resulting in a negative value.

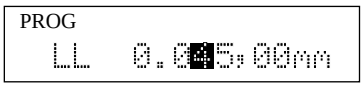


If the [>] key is pressed, the digit places are automatically filled with zeros to reflect the set resolution, with the appropriate number of commas inserted after the thousandth digit, then the most significant digit that can be set starts flashing.

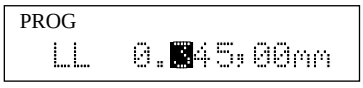
Here, for practice, press the [<] key.

3) Press the [<] key twice to move the digit to be set to the third digit place, then press the [∧] key five times.

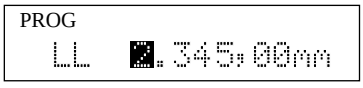
4) Press the [<] key to move the digit to be set to the forth digit place, then press the [∧] key four times.



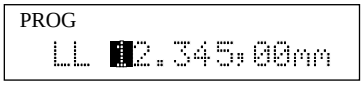
5) Press the [<] key to move the target digit to be set to the fifth digit, then press the [∧] key three times.



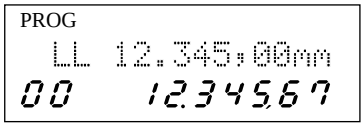
6) Press the [<] key to move the digit to be set to the sixth digit place, then press the [∧] key twice.



7) Press the [<] key to move the target digit to be set to the seventh digit place, then press the [∧] key.



8) Press the [ENT] key to save the setup value in memory.



NOTE Rounding setup value

Setup value will be rounded off automatically if its least significant digit does not agree with the resolution of the display.

Example: In case the resolution is 0.05 μm

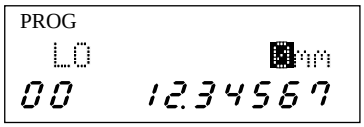
12.345,64 > 12.345,60 (least significant digit 4 is rounded off to 0)

12.345,67 > 12.345,65 (least significant digit 7 is rounded off to 5)

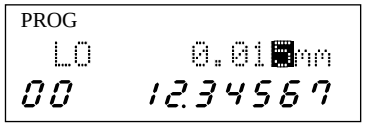
TIP About the input of setup data

1. How to enter a sign

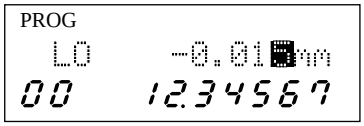
   If "Perform GO/NG judgment by (target value + tolerance)" has been specified in the basic setup and the lower tolerance limit is "-0.015", input as follows. In this case a "0" does not need to be placed in the integer section.



([0]) [.] [0] [1] [5]



[+/-]



2. [READ] key: About the read operation

   Generally, in the calibration or offset value setup operation a reference gage is used, resulting in a measured data that is very close to the setup value. If this is the case, first read a measurement as the setup data, then correct the minor difference.

3. To enter a numeric value such as a gage diameter, it is more convenient to use the numeric keys. To correct a specific digit, it is more convenient to use the arrow keys.

4. To select a setup item such as the resolution in the basic setup, it is better to use the [∧] or [∨] key. Use of a numeric key causes an operation error.

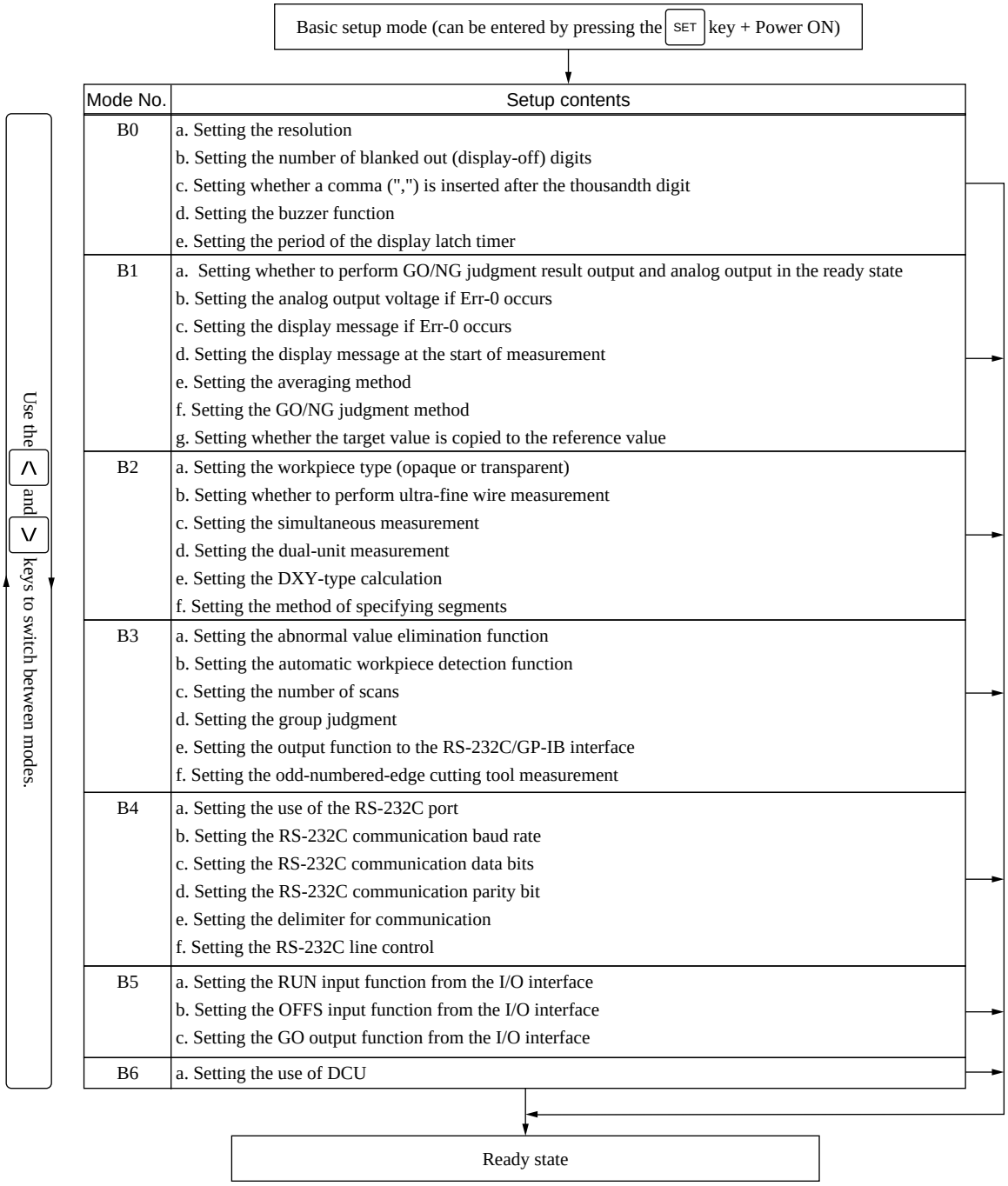
4 SETTING UP THE MEASURING CONDITIONS

Set up the various functions as required to customize the system for the utmost measurement accuracy.

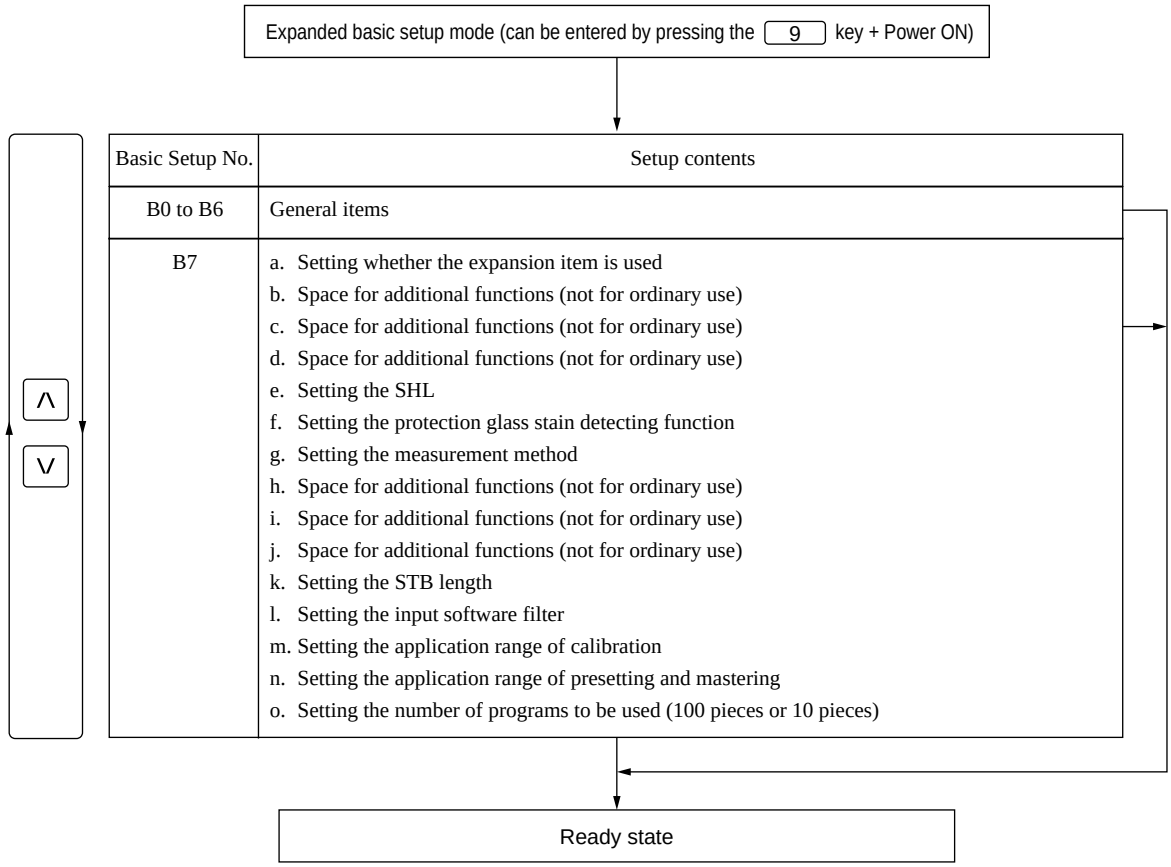
4.1 Basic Setup

- In the basic setup mode select and modify the appropriate functions to meet your measuring purpose. It is not necessary to set up functions which will not be used.
- The basic setup should be performed at the beginning of operation.
  Modification of the basic setup after calibration or function setup has been made may result in the cancellation of the calibration or function setup values.
- RS-232C/GP-IB commands and input from the (Second) Analog I/O Interface can not be accepted in the basic setup mode.

4.1.1 Outline of the basic setup procedure



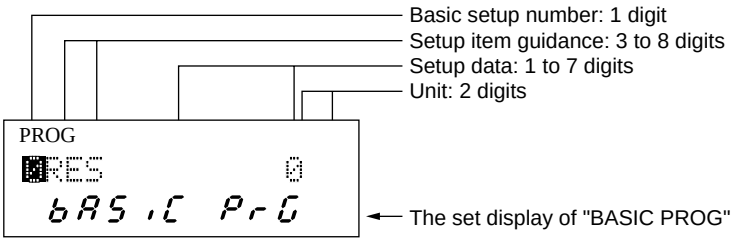
Mode No.	Setup contents
B0	a. Setting the resolution b. Setting the number of blanked out (display-off) digits c. Setting whether a comma (",") is inserted after the thousandth digit d. Setting the buzzer function e. Setting the period of the display latch timer
B1	a. Setting whether to perform GO/NG judgment result output and analog output in the ready state b. Setting the analog output voltage if Err-0 occurs c. Setting the display message if Err-0 occurs d. Setting the display message at the start of measurement e. Setting the averaging method f. Setting the GO/NG judgment method g. Setting whether the target value is copied to the reference value
B2	a. Setting the workpiece type (opaque or transparent) b. Setting whether to perform ultra-fine wire measurement c. Setting the simultaneous measurement d. Setting the dual-unit measurement e. Setting the DXY-type calculation f. Setting the method of specifying segments
B3	a. Setting the abnormal value elimination function b. Setting the automatic workpiece detection function c. Setting the number of scans d. Setting the group judgment e. Setting the output function to the RS-232C/GP-IB interface f. Setting the odd-numbered-edge cutting tool measurement
B4	a. Setting the use of the RS-232C port b. Setting the RS-232C communication baud rate c. Setting the RS-232C communication data bits d. Setting the RS-232C communication parity bit e. Setting the delimiter for communication f. Setting the RS-232C line control
B5	a. Setting the RUN input function from the I/O interface b. Setting the OFFS input function from the I/O interface c. Setting the GO output function from the I/O interface
B6	a. Setting the use of DCU


Expanded basic setup mode (can be entered by pressing the 9 key + Power ON)
Basic Setup No.
Setup contents
B0 to B6
General items
B7
a. Setting whether the expansion item is used
b. Space for additional functions (not for ordinary use)
c. Space for additional functions (not for ordinary use)
d. Space for additional functions (not for ordinary use)
e. Setting the SHL
f. Setting the protection glass stain detecting function
g. Setting the measurement method
h. Space for additional functions (not for ordinary use)
i. Space for additional functions (not for ordinary use)
j. Space for additional functions (not for ordinary use)
k. Setting the STB length
l. Setting the input software filter
m. Setting the application range of calibration
n. Setting the application range of presetting and mastering
o. Setting the number of programs to be used (100 pieces or 10 pieces)
Λ
V
Ready state

4.1.2 Description of each mode

1. Data display unit

If the basic setup mode is entered, the following display appears.
The basic setup number "0" will be flashing in the most significant digit of the upper display section, and the guidance for the setup item, followed by the setup value, will be shown at the right of the setup number.
In the lower display section "bAS.C PrG" will be displayed.



2. Selecting the basic setup number

- Each time the [∧] key is pressed when the basic setup number is flashing the function setup number digit changes as follows: 0 → 1 → 2 → 3 → 4 → 5 → 6 → 0. To enter the desired setup mode press the [ENT] key when its setup number is flashing. If the [∨] key is pressed, the setup mode will change in reverse order.
- If a key other than [∧], [∨], [ENT], or [SET] is pressed during the selection of a basic setup number an operation error will result.
- When each piece of setup data is accepted with the [ENT] key in the corresponding setup mode, the operation will automatically proceed to the next setup item.

3. Setting each setup item

- Except for setting up the display latch timer, select the setup item using the [∧] or [∨] key and accept the setup specification by pressing the [ENT] key. When the setup content is accepted, the operation will automatically proceed to the next setup item. In setting the display latch timer, it is better to use the numeric keys rather than the arrow keys, which, however, are valid.

4. Confirming the setup contents of each setup item

To confirm the setup specification of each setup item use only the [ENT] key, which does not affect the setup specifications.

5. Terminating the basic setup mode

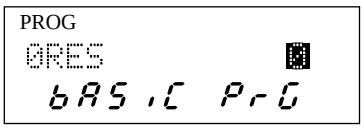
- If the [SET] key is pressed while the basic setup number is flashing, the setup contents modified in this session will be saved, and the system will restore the state that is entered just after the power is turned on.
- If the [SET] key is pressed in the setup mode of each setup item, the operation returns to the selection of a basic setup number. If the [SET] key is pressed again at this point , the setup contents modified in this session will be saved, and the system will restore the state that is entered just after the power is turned on.
- If the power is turned off halfway the setup operation, setup specifications made will not be saved. If this is the case, setup should be repeated from the beginning.

4.1.2.1 Selecting and setting the function in the B0 mode

a. Setting the resolution (Guidance: RES)

Set the resolution of the Measuring Unit. The resolutions that can be set for the Measuring Units are given in "Table 4.5.2.1A" and "Table 4.5.2.1B".

Step 1: Each time the [∧] key is pressed the displayed setup option (number) changes in the following order: 0 → 1 → 2... → 6 → 7 → 0. If the desired option is flashing, press the [ENT] key. If the resolution setting has been made, the operation automatically proceeds to the setting for the number of blanked out digits.
The initial setup option is set to 0.



1. Resolution using the metric system (Unit: μm) Table 4.5.2.1A

Model name	0	1	2	3	4	5	6	7
LSM-500S	0.01	0.02	0.05	0.1	0.2	0.5	1	10
LSM-501S	0.01	0.02	0.05	0.1	0.2	0.5	1	10
LSM-503S	0.02	0.05	0.1	0.2	0.5	1	10	100
LSM-506S	0.05	0.1	0.2	0.5	1	2	10	100
LSM-512S	0.1	0.2	0.5	1	2	5	10	100
LSM-516S	0.1	0.2	0.5	1	2	5	10	100

2. Resolution using the inch system (Unit: inch) Table 4.5.2.1B

Model name	0	1	2	3	4	5	6	7
LSM-500S	.000001	.000001	.000002	.000005	.00001	.00002	.00005	.0005
LSM-501S	.000001	.000001	.000002	.000005	.00001	.00002	.00005	.0005
LSM-503S	.000001	.000002	.000005	.00001	.00002	.00005	.0005	.005
LSM-506S	.000002	.000005	.00001	.00002	.00005	.0001	.0005	.005
LSM-512S	.000005	.00001	.00002	.00005	.0001	.0002	.0005	.005
LSM-516S	.000005	.00001	.00002	.00005	.0001	.0002	.0005	.005

Note 1: The shaded figures show the default setting of each Measuring Unit.
Note 2: Resolutions in the columns of " 0" show those which can be obtained from 32 scans. Resolutions in the columns with " 1" show those which can be obtained from 16 scans.
Note 3: If the number of scans are set between 1 to 8, the least significant digit of a measurement will be automatically blanked out where resolution is set to No.0, 1, or 2.
Note 4: Note that setting a too large resolution may often reduce the measuring accuracy. Where the displayed digits are closely intact and difficult to see, set the number of blank-out digits or mark the thousandth digit function in the basic setup mode: b0.

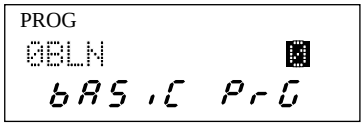
IMPORTANT Changing the resolution will cancel all the clibration values (HIGH CAL and LOW CAL), offset value, mastering, abnormal value eliminating limits, GO/NG judgment criteria, reference value, and setup values for the automatic workpiece detection. Therefore, changing of the resolution should be carried out first.

b. Setting the number of blank-out digits (Guidance: BLN)

Here, set the number of blank-out digits for measurements to be displayed in the display unit. This blank out does not apply to the output to BCD interface, RS-232C/GP-IB interface, printer, Digimatic output unit, and the display of setup value.

0 : No blank out (all digits are displayed) → 12.34567
1 : The least significant digit is blanked out. → 12.3456
2 : The least significant two digits are blanked out. → 12.345
(Default setting is 0.)

Step 1: Each time the [∧] key is pressed the displayed figure changes in ascending order: 0 → 1 → 2 → 0.
While the figure to be set is flashing, press the [ENT] key.
After accepting the specified value, the display proceeds to the setup stage of the next item.

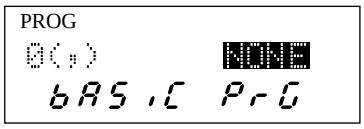


c. Putting a comma after the thousandths digit (Guidance: (,))

Set whether a comma (,) is inserted after the thousandths digit.

NONE : Not displayed → 12.34567
USE : Displayed → 12.345,67
(Default setting is NONE.)

Step 1: Each time the [∧] key is pressed the displayed string toggles between NONE and USE.
Select the setting and press the [ENT] key.
After accepting the specified digit position, the display proceeds to the setting the buzzer function.



d. Setting the buzzer function (Guidance: BUZZER)

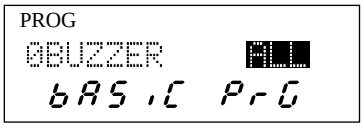
Set whether or not to enable (key input sensing sound and key entry error sound) and (±NG judgment sound). Note that the system error sounds (indicating that the printer or Digimatic Output Unit is not connected, or other system failures) are not disabled with this setting.

The types of buzzer sound are as follows:

1. Key input sensing sound: very short beep (0.05 sec)
2. Key entry error sound: short beep (0.2 sec)
3. ±NG judgment sound: long beep (1 sec)
4. System error sound: repeated short beeps at intervals of 0.2 seconds

ALL : Sounds a buzzer in all cases.
KEY : Enables the key input sensing sound + key entry error sound
NG : Sounds a buzzer when the judgment result is ±NG
NONE : Sounds a buzzer only if a system error occurs
(Default setting: ALL)

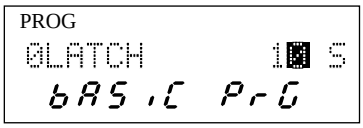
Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: ALL → KEY → NG → NONE. If the desired option is flashing, press the [ENT] key. When the setup for the buzzer function is completed, operation automatically proceeds to the setting of the display latch timer.



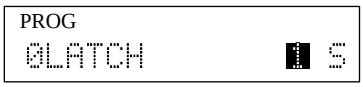
e. Setting the display latch timer (Guidance: LATCH)

Set the period the measurement result display is to be latched (held) on the display if a single-run measurement or continuous-run measurement is performed. Specify a value between 0 and 99 seconds. “0” seconds specifies an infinite (latch state not canceled). (Default setting: 10 seconds)

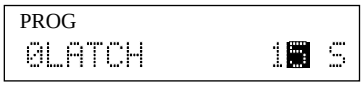
Step 1: This is an example of the display latch timer being set to 15 seconds.
Enter [1] and [5] in this order.



[1]

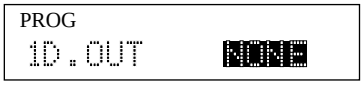


[5]



Step 2: Press the [ENT] key to save the setup data in memory.
The operation automatically proceeds to B1: Setting the output function in the ready state.

[ENT]



4.1.2.2 Selecting and setting the function in the B1 mode

a. Setting the output function in the ready state (Guidance: D.OUT)

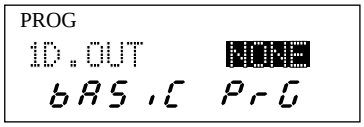
Set whether to perform GO/NG judgment result output and analog output in the ready state.

NONE : Neither kind of output is performed in the ready state.

OUT : Both kinds of output are performed, even in the ready state.

(Default setting: NONE)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between NONE and OUT. While the desired setup option is flashing, press the [ENT] key. When the setup for this function has been completed, the operation automatically proceeds to the setting for the analog output voltage in the event of Err-0.



b. Setting the analog output voltage if Err-0 occurs (Guidance: ERR-0 V)

Set the analog output voltage in the event of Err-0 (specified workpiece not present).

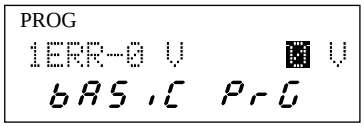
0 : Output voltage 0V

+5 : Output voltage +5V

-5 : Output voltage -5V

(Default setting: 0 V)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: 0 → +5 → -5. While the desired setup option is flashing, press the [ENT] key. When the setup for this function has been completed, the operation automatically proceeds to the selection of the display message for Err-0.



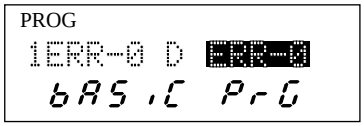
c. Selecting the display message if Err-0 occurs (Guidance: ERR-0 D)

ERR-0 : Displays "ERR-0".

0 : Displays "0" as the least significant digit.

(Default setting: ERR-0)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between ERR-0 and 0. While the desired setup option is flashing, press the [ENT] key. The operation automatically proceeds to the selection of the display message at the start of measurement.



d. Selecting the display message at the start of measurement (Guidance: RUN D)

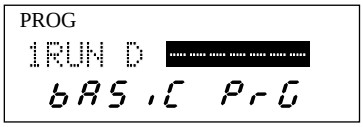
Set the message to be displayed at the start of a single-run measurement or continuous-run measurement.

———— : Displays "———".

PREV.D : Continuously displays the previous data.

(Default setting: ————)

Step 1: Each time the △ key is pressed the displayed setup option toggles between ———— and PREV.D. While the desired setup option is flashing, press the ENT key. The operation automatically proceeds to the selection of the averaging method.



e. Selecting the averaging method (Guidance: AVG.M)

Select one of the following averaging methods: arithmetical average and moving average.

ARITHM : Arithmetical average

MOVING : Moving average

(Default setting: ARITHM)

Step 1: Each time the △ key is pressed the displayed setup option toggles between ARITHM and MOVING. While the desired setup option is flashing, press the ENT key. The operation automatically proceeds to the selection of the GO/NG judgment method.

f. Setting the GO/NG judgment method (Guidance: JDG.M)

Select one of the following GO/NG judgment methods: (lower limit value and upper limit value), (multi-limit selection: 7 stages), and (target value + tolerance).

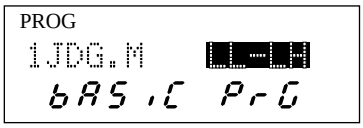
L-H : GO/NG judgment is performed according to the specified lower limit and upper limit.

1-6 : GO/NG judgment is performed according to the multi-limit selection (7 limits).

NO-UL : GO/NG judgment is performed according to the specified target value and tolerance.

(Default setting: L-H)

Step 1: Each time the △ key is pressed the displayed setup option changes in the following order: L-H → 1-6 → NO-UL. While the desired setup option is flashing, press the ENT key. If NO-UL is selected, operation proceeds to setting whether the target value is copied to the reference value. If NO-UL is not selected, operation proceeds to B2: Setting the workpiece type.



g. Setting whether the target value is copied to the reference value (Guidance: COPY)

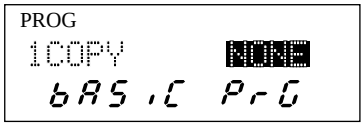
Set whether the target value is automatically copied to the reference value.

NONE : Target value is not copied to the reference value.

NO-REF : Target value is copied to the reference value.

(Default setting: NONE)

Step 1: Each time [∧] key is pressed the displayed setup option toggles between NONE and NO-REF. While the desired setup option is flashing press [ENT] key. The operation automatically proceeds to setting B2: Setting the workpiece type.



4.1.2.3 Selecting and setting the function in the B2 mode

a. Setting the workpiece type (Guidance: WORK.P)

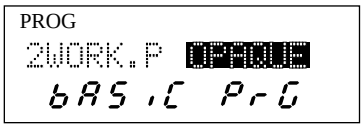
Set whether the workpiece is an opaque object or transparent object.

OPAQUE : Workpiece is an opaque object.

TRANS : Workpiece is a transparent object.

(Default setting: OPAQUE)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between OPAQUE and TRANS. While the desired setup option is flashing, press the [ENT] key. The operation automatically proceeds to setting whether to perform ultra-fine wire measurement.



TIP If TRANS is selected for the workpiece type, the guidance for the selection of the segment specification method is not displayed. It is omitted (the segment specification process is entered directly).

b. Setting whether to perform ultra-fine wire measurement (Guidance: FINE)

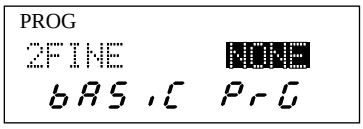
Set whether to perform the ultra-fine wire measurement.

FINE : Performs ultra-fine wire measurement.

NONE : Does not perform ultra-fine wire measurement.

(Default setting: FINE on the LSM-500S and other models that have been factory set for extra-fine wire measurement; otherwise no setup guidance will be displayed).

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between NONE and FINE. While the desired setup option is flashing, press the [ENT] key. If FINE is selected, the operation automatically proceeds to B3: Setting abnormal value elimination function. Otherwise, proceeds to Setting the simultaneous measurement.



NOTE About ultra-fine wire measurement

1. If the Display Unit is initialized (turn on the power while holding down the [C] key) on the LSM-500S, the FINE option for ultra-fine wire measurement becomes the default setting.
2. If NONE is selected on the LSM-500S so that ultra-fine wire measurement is not performed, the following measuring range will be applied.

Measuring range	Standard (factory) set measuring range	if ultra-fine wire measurement is not to be performed
LSM-500S	0.005 to 2 mm	0.1 to 2 mm

TIP If FINE is selected to perform ultra-fine wire measurement, setup guidance for the following will not be displayed: Setting the simultaneous measurement, setting the dual-measurement, segment setting, setting the automatic workpiece detection function, and group judgment.

c. Setting the simultaneous measurement (Guidance: PROG)

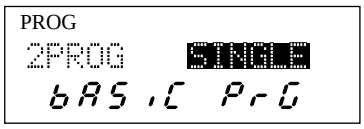
Set whether to perform simultaneous measurement.

SINGLE : Does not perform simultaneous measurement. (performs single measurement)

DUAL : Performs simultaneous measurement.

(Default setting: SINGLE)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between SINGLE and DUAL While the desired setup option is flashing, press the [ENT] key. Operation automatically proceeds to setting the dual-unit measurement.



TIP If DUAL (simultaneous measurement) is selected

If simultaneous measurement is selected, the setup guidance for the following will not be displayed: Selecting the averaging method, segment specification, and setting the group judgment.

d. Setting the dual-unit measurement (Guidance: TYPE)

Set whether to perform dual-unit measurement.

DW : Uses DW-type setup.

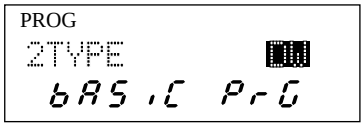
DXY : Uses DXY-type setup.

DF : Uses DF-type setup.

NONE : Suspends operation of a Measuring Unit.

(Default setting: DW)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: DW → DXY → DF → NONE. While the desired setup option is flashing, press the [ENT] key. If DXY is selected, the operation enters the process for setting the calculation method for the DXY-type; if DW or NONE is selected, the operation enters the setup process for segment specification; if DF is selected, the operation enters the process for setting the abnormal value elimination function.

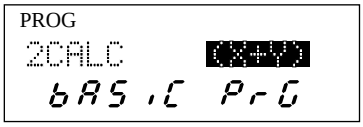


e. Setting the DXY-type calculation (Guidance: CALC)

Set the method for calculating the measurements obtained from two Measuring Units.

(X+Y) : Calculates a sum, (X+Y).
(X+Y)/2 : Calculates a mean, (X+Y) /2.
(X-Y) : Calculates a difference, (X-Y).
(X-Y)/2 : Calculates half of the difference, (X-Y) /2.
(Default setting: (X+Y))

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: (X+Y) → (X+Y)/2 → (X-Y) → (X-Y)/2. While the desired setup option is flashing, press the [ENT] key. The operation automatically proceeds to B3: Setting the abnormal value elimination function.

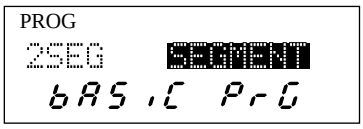


f. Selecting the method of specifying segments (Guidance: SEG)

Select the method of specifying the measurement position from segment specification and edge specification.

SEGMENT : Uses segment specification.
EDGE : Uses edge specification.
(Default setting: SEGMENT)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between SEGMENT and EDGE. While the desired setup option is flashing, press the [ENT] key. The operation automatically enters B3: Setting the abnormal value elimination function.



NOTE If any of the following setting is performed, the system automatically proceeds to the stage of segment setup SEGMENT without displaying the guidance for the method of specifying segments SEG:

1. a. TRANS is selected in Setting the workpiece type.
2. b. FINE is selected in setting whether to perform ultra-fine wire measurement.
3. d. DXY or DF is selected in setting the dual-unit measurement

4.1.2.4 Selecting and setting the function in the B3 mode

a. Setting the abnormal value elimination function (Guidance: ADE)

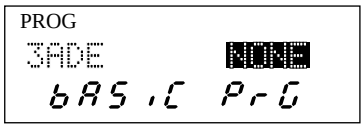
Set whether to use the abnormal value elimination function.

NONE : Does not use the abnormal value elimination function.

USE : Use the abnormal value elimination function.
If the number of samples has been set, measurement will be finished when the measured data within the limit value are obtained for the specified sample number, and calculation is performed only with the within-the-limit data for displaying the measurement result.

USE2 : Use the abnormal value elimination function.
If the number of samples has been set, measurement will be performed for the specified sample number and displays the measurement result after a calculation has been performed only with the within-the-limit data. The message "Err-0" will be displayed if no data is obtained within the limit value.
(Default setting: NONE)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in following order :
NONE → USE → USE2.
While the desired setup option is flashing, press the [ENT] key. The operation automatically enters the process for setting the automatic workpiece detecting function.



b. Setting the automatic workpiece detecting function (Guidance: AWDT)

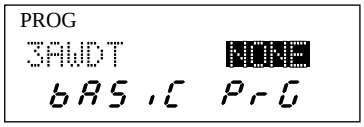
Set whether to use the automatic workpiece detecting function.

NONE : Does not use the automatic workpiece detecting function.

DIA : Performs automatic workpiece detection with the diameter detection method.

POSITN : Performs automatic workpiece detection with the position detection method.
(Default setting: NONE)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order:
NONE → DIA → POSITN. While the desired setup option is flashing, press the [ENT] key. If NONE (the automatic workpiece detecting function is not used) is selected, the operation proceeds to setting the group judgment, otherwise it enters the process for setting the number of scans.



c. Setting the number of scans (Guidance: SCAN)

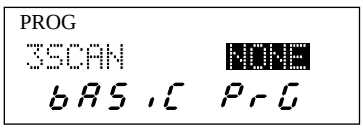
Set the number of scans that are used for the automatic workpiece detecting function.

16 : Detection from 16 scans

1 : Detection from a single scan

(Default setting: 16)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between 16 and 1. While the desired setup option is flashing, press the [ENT] key. The operation automatically enters the process for setting the group judgment.



NOTE Even if 16 scans are specified in the position detection method, the actual detecting operation will be performed with a single scan.

d. Setting the group judgment (Guidance: GTJ)

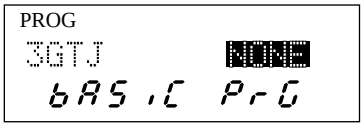
Set whether to use the group judgment function.

NONE : Does not use the group judgment function.

USE : Uses the group judgment function.

(Default setting: NONE)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between NONE and USE. While the desired setup option is flashing, press the [ENT] key. If NONE is selected, the operation proceeds to B4: Setting the use of RS-232C baud rate, and if USE is selected, the operation enters the process for setting the group judgment result output function.



e. Setting the group judgement output (Guidance: GTJ D)

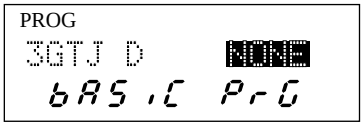
Set whether to output the group judgment result to the RS-232C/GP-IB interface.

NONE : Does not output the group judgment result to the RS-232C/GP-IB interface.

OUT : Outputs the group judgment result to the RS-232C/GP-IB interface.

(Default setting: NONE)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between NONE and OUT. While the desired setup option is flashing, press the [ENT] key. The operation automatically proceeds to B4: Setting the use of RS-232C port.



f. Setting the odd-numbered-edge cutting tool measurement function (Guidance : TOOL)

Set whether the odd-numbered-edge cutting tool measurement function is used.

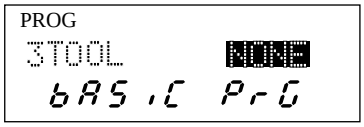
NONE : Does not use the odd-numbered-edge cutting tool measurement function.

USE1 : Uses the odd-numbered-edge cutting tool measurement function.
This must be selected when the reference edge is located at the Segment 1 side.

USE3 : Uses the odd-numbered-edge cutting tool measurement function.
This must be selected when the reference edge is located at the Segment 3 side.
(Initial setting : NONE)

Step 1 : Each time the [∧] key is pressed, the selection item will change sequentially as follows:

Step 2 : If the [ENT] key is pressed while the target selection item is blinking, the current setup is accepted and the operation will automatically proceed to B4: Setting the RS-232C port.



NOTE If one of the following setup items are selected, "NONE : Does not use the odd-numbered-edge cutting tool measurement function" will be automatically accepted as the intended setting without showing the setup guidance for odd-numbered-edge cutting tool measurement.

1. Where "MOVING : Moving average" is set for the "B1.e. Setting the averaging method".
2. Where "FINE : Ultra-fine wire measurement" is set for the "B2.b. Setting whether the Ultra-fine wire measurement is performed".
3. Where "DUAL : Simultaneous measurement" is set for the "B2.c. Setting the simultaneous measurement".
4. Where "DW, DXY, or DF" is set for the "B2.d. Setting the dual measurement".
5. Where "EDGE : Edge specification" is set for the "B2.f. Selecting the segment specification method".
6. Where "DTH or POSITN" is set for the "B3.b. Setting the workpiece automatic detection".

TIP For practical measurement examples refer to Section 5.3.6 "Application of the odd-numbered-edge cutting tool measurement".

4.1.2.5 Selecting and setting the function in the B4 mode

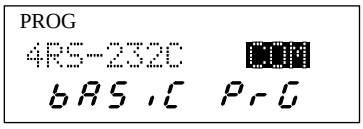
a. Setting the use of RS-232C port (Guidance: RS-232C)

Set if the RS-232C port is used as the communication port (COM) for a personal computer, etc., or as the printer port, or is not used for either.

Except for use as the communication port (COM), the GP-IB interface can take the place of the RS-232C.

COM : Used as the communication port (COM) for a personal computer, etc.
PRN : Used as the printer port (GP-IB can be used)
NONE : Is not used for either purpose (GP-IB can be used)
(Default setting: COM)

Step 1: Each time the key is pressed the displayed setup option changes in the following order: COM → PRN → NONE. While the desired setup option is flashing, press the [ENT] key. If NONE is selected, the operation proceeds to B5: Setting the RUN input function from the I/O interface, otherwise it enters the process for setting the RS-232C communication speed.

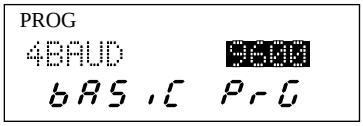


b. Setting the RS-232C communication baud rate (Guidance: BAUD)

Set the RS-232C communication speed (baud rate).

9600 : Uses 9600 bps.
19200 : Uses 19200 bps.
38400 : Uses 38400 bps.
4800 : Uses 4800 bps.
(Default setting: 9600)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: 9600 → 19200 → 38400 → 4800. While the desired setup option is flashing, press the [ENT] key. The operation automatically enters the process for setting the RS-232C data bits.

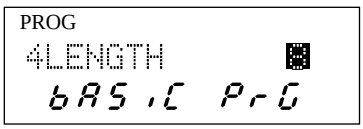


c. Setting the RS-232C communication data bits (Guidance: LENGTH)

Set the data bits for RS-232C communication.

8 : Uses 8 bits.
7 : Uses 7 bits.
(Default setting: 8)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between 8 and 7. While the desired setup option is flashing, press the [ENT] key. The operation automatically enters the process for setting the parity check method for RS-232C communication.

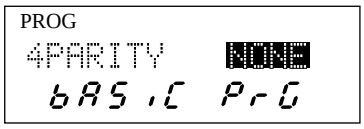


d. Setting the RS-232C communication parity bit (Guidance: PARITY)

Set the parity check method for RS-232C communication.

NONE : Does not use parity check.
ODD : Uses odd parity.
EVEN : Uses even parity.
(Default setting: NONE)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: NONE → ODD → EVEN. While the desired setup option is flashing, press the [ENT] key. The operation automatically enters the process for setting the delimiter for RS-232C communication .

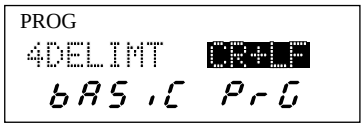


e. Setting the delimiter for communication (Guidance DELIMT)

Set the delimiter (termination code of one sentence) for RS-232C communication.

CR+LF : Uses CR+LF as the delimiter.
CR : Uses CR code as the delimiter.
LF : Uses LF code as the delimiter.
(Default setting: CR+LF)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: CR+LF → CR → LF. While the desired setup option is flashing, press the [ENT] key. The operation automatically enters the process for setting the control method of the RS-232C communication flow.



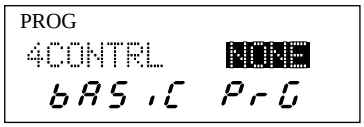
f. Setting the RS-232C line control (Guidance: CONTRL)

Set the method of controlling the RS-232C communication flow.

NONE : Does not use a particular control signal (using 3-wire teletype control).
USE : Uses a control signal.
(Default setting: NONE)

Note: If the RS-232C interface is set as the printer port, line control will be achieved by BUSY signals even if this option was set to NONE.

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between NONE and USE. While the desired setup option is flashing, press the [ENT] key. The operation automatically proceeds to B5: Setting the RUN input function from the I/O interface.



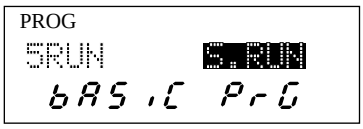
4.1.2.6 Selecting and setting the function in the B5 mode

a. Setting the RUN input function from the I/O interface (Guidance: RUN)

Set if the RUN input from the I/O interface is used to trigger single-run measurement, continuous-run measurement with a term specification, or continuous-run measurement. If the function is used for triggering continuous-run measurement with a term specification, RUN input from the Second Analog I/O Interface will also be used for triggering the same kind of measurement.

S.RUN : Used to trigger single-run measurement.
T.RUN : Used to trigger continuous-run measurement with a term specification
C.RUN : Used to trigger continuous-run measurement.
(Default setting: S.RUN)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: S.RUN → T.RUN → C.RUN. While the desired setup option is flashing, press the [ENT] key. The operation automatically enters the process for setting the OFFS input function from the Analog I/O Interface.

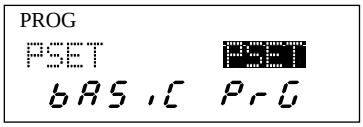


b. Setting the PSET input function from the I/O interface (Guidance: PSET)

Set whether the PSET input from the Analog I/O Interface is used for enabling the preset function or holding the displayed value (while this signal is on, neither the GO/NG judgment result nor the analog output value is updated). If the function for holding the displayed value is selected, SHIFT + RUN input from the Second Analog Interface is also treated as being the same function.

PSET : Uses the input signal to enable the preset function.
HOLD : Uses the input signal to hold the value.
(Default setting: PSET)

Step 1: Each time the [∧] key is pressed the displayed setup option toggles between PSET and HOLD. While the desired setup option is flashing, press the [ENT] key. The operation proceeds to B6: Setting the use of DCU if the Second Analog I/O interface is installed. Otherwise the operation proceeds to the Setting the GO output function from the I/O interface.

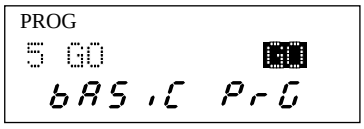


c. Setting the GO output function from the I/O interface (Guidance: GO)

Set whether the GO output from the Analog I/O Interface is used as $\overline{GO}$, $\overline{STB}$ (strobe), or $\overline{ACK}$ (acknowledgment). This selection does not apply to the Second Analog I/O Interface, since it has its specific output port. For information about each signal, refer to Section 6.1.1, "I/O Analog Interface".

GO : Used as a $\overline{GO}$ output.
STB : Used as a $\overline{STB}$ output.
ACK : Used as an $\overline{ACK}$ output.
(Default setting: GO)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: GO → STB → ACK. While the desired setup option is flashing, press the [ENT] key. The operation automatically proceeds to B6: Setting the use of DCU.



NOTE If the Second Analog I/O Interface Unit is used
The Second Analog I/O Interface Unit, if installed, will also perform the function of the standard analog I/O interface unit except the analog output through the I/O port.

4.1.2.7 Selecting and setting the function in the B6 mode

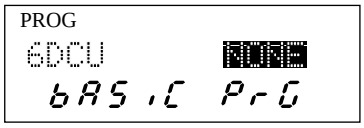
a. Setting the use of DCU (Guidance: DCU)

Set whether to use the Mitutoyo DP-series Data Processing Unit called DCU (Digimatic Output Unit).

The setup guidance for this option will be displayed only if the dedicated interface has been installed.

NONE : Does not use DCU.
DCU1 : Only uses the OUTPUT-1 interface from the two interface units.
BOTH : Uses both interface units.
(Default setting: NONE)

Step 1: Each time the [∧] key is pressed the displayed setup option changes in the following order: NONE → DCU1 → BOTH. While the desired setup option is flashing, press the [ENT] key. The operation automatically returns to B0: Setting the resolution.



NOTE About the setting of a DCU
If BOTH is specified so two interfaces are used for single measurement, the OUTPUT-2 will be ignored.

4.1.2.8 Setting in the B7 mode (expanded items)

To use this mode, turn on the power while pressing the [9] key. Items in this mode will be displayed for selection after the display of the basic setup items in the B6 mode.

IMPORTANT

- If expanded items (of the mode of B7) that are not required are displayed, cancel the display by setting NONE in place of ADD for the expanded item setup.
- For setting in the space for additional function always select 0 which is the default or NONE. If this setting is carelessly modified, this Unit will operate unexpectedly such as to disable any measurement.

a. Setting expanded items (Guidance: ADD)

Set whether to use (display) the function of expanded items.

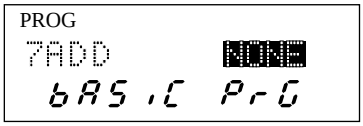
NONE : No use (display) of the expanded item

USE : Use (display) of the expanded item

(Default setting: NONE)

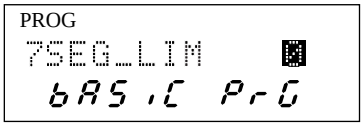
Step 1: Setting changes between NONE and USE at each entry of [∧] .

Step 2: Press the [ENT] key while the setting is flashing. When this entry is made, the next setting item will be displayed.



b. Reservation (Guidance: SEG_LIM)

(Default setting: 0)



c. Reservation (Guidance: SEG_ER0)

(Default setting: 0)

d. Reservation (Guidance: SEG_COR)

(Default setting: NONE)

e. SHL setting (Guidance: SHL)

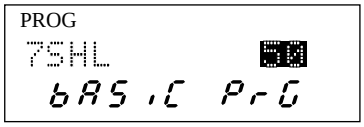
Sets up the SHL value for the measurement of, for example, the transparent sheet width. To use this function, set USE for "a. Expanded item" and OFF for "g. Setting measurement mode". For detailed information about this setting, refer to Section 3.2.4.1, "Transparent object".

Be aware that any change in the parameter setting greatly affects the measured data (measuring accuracy).

(Default value: 50(%))

Setting value is an integer between 5% and 95%.

Step 1: Enter a value with numeral keys while the setting is flashing.
Step 2: Press the [ENT] key while an entered value is flashing. After the entry is made, the next setting item will be displayed.

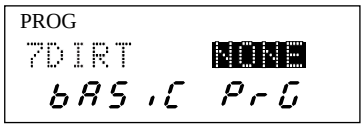


f. Setting for detecting dirty protection glass (Guidance: DIRT)

Sets the function for detecting dirty protection glass. (Functions at power on.)
If the protection glass is dirty, ERR-16 will be displayed. This error display can be cleared by pressing the [C] key. The ready state will be entered.
If the protection glass is found to be dirty, refer to Section 8.2, "Measuring Unit".
A warning will be issued if the protection glass has become too dirty and measuring accuracy will be affected. To ensure precision measurements, clean the protection glass before any warning is likely to be issued.

NONE : No use of the dirty protection glass detection function.
USE : Use of the dirty protection glass detection function.
(Default value: NONE)

Step 1: Setting changes between NONE and USE at each entry of [∧].
Step 2: Press the [ENT] key while the setting is flashing. After the entry is made, the next item to be set will be displayed.



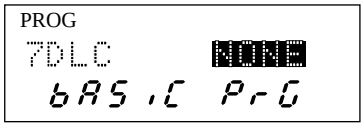
NOTE A very small workpiece (e.g., smaller than 0.05 mm for the LSM-500S) is likely to be regarded as a piece of dirt. If a very small workpiece is to be measured, perform a check with the workpiece removed.

g. Setting the measurement mode (Guidance: DLC)

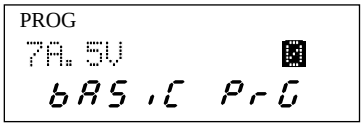
Used to select measurement mode for measurement of, for example, the transparent sheet width. For detailed information, refer to Section 3.2.4.1 Transparent object.
Be aware that any change in the parameter setting greatly affects the measured data (measuring accuracy).

NONE : Use this setting for ordinary measurements.
ON : Do not use this setting for ordinary measurements.
OFF : Only select for changing the SHL settings.
(Default value: NONE)

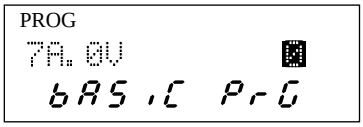
Step 1: Setting changes to NONE , ON , and USE in this sequence for each entry of [∧] .
Step 2: Press the [ENT] key while the setting is flashing. After this entry is made, the next item to be set will be displayed.



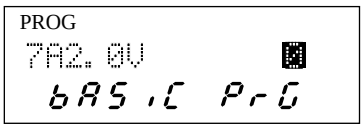
h. Space for additional functions (Guidance: A.5V)
(Initial setting : 0)
If the ENT is entered, the operation automatically proceeds to the next setting.



i. Space for additional functions (Guidance: A.0V)
(Initial setting : 0)
If the ENT is entered, the operation automatically proceeds to the next setting.



j. Space for additional functions (Guidance: A2.0V)
(Initial setting : 0)
If the ENT is entered, the operation automatically proceeds to the next setting.

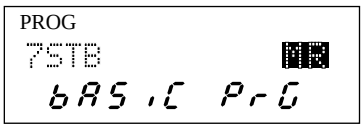


k. Setting the STB length of I/O analog interface (Guidance: STB)
Selects the $\overline{\text{STB}}$ length of the I/O Analog Interface (strobe) output.

- AU : Automatically makes up the setting with the specified number of averages.
- 0.1 : STB length = 0.1 ms
- 0.3 : STB length = 0.3 ms
- 2 : STB length = 2 ms
- 5 : STB length = 5 ms
- 10 : STB length = 10 ms
- 20 : STB length = 20 ms
- 50 : STB length = 50 ms
- 100 : STB length = 100 ms

(Initial setting: AU)

Step 1: Each time the ∧ key is pressed, the selection item will change sequentially as follows:
AU → 0.1 → ... → 100 → AU



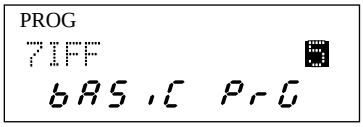
Step 2: If the ENT key is pressed while the target selection item is blinking, the current setup is accepted and the operation will automatically proceed to the next setting.

l. Setting the input software filter (Guidance: IFF)
Select the filter length for input signals.

- 5 : Filter length = 5 ms
- 20 : Filter length = 20 ms
- 2 : Filter length = 2 ms

(Initial setting: 5)

Step 1: Each time the ∧ key is pressed, the selection item will change sequentially as follows:
5 → 20 → 2



Step 2: If the ENT key is pressed while the target selection item is blinking, the current setup is accepted and the operation will automatically proceed to the next setting.

m. Setting the application range of calibration (Guidance: CAL)

Select the range of applying the calibration from "All programs" and "For each channel".

ALL : Applies uniformly to the entire programs.

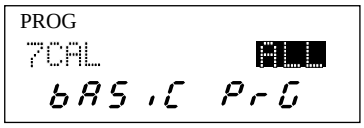
CH : Applies individually to each channel (for every 10 program).

(Initial setting: ALL)

Step 1: Each time the [∧] key is pressed, the selection item will change sequentially as follows:

ALL → CH

Step 2: If the [ENT] key is pressed while the target selection item is blinking, the current setup is accepted and the operation will automatically proceed to the next setting.



NOTE When CH is selected, any programs corresponding to the channel number other than the one on which the calibration has been performed will take the settings at shipment, i.e. without being calibrated.

n. Setting the application range of presetting and mastering (Guidance: PST)

Select the range of applying the presetting and mastering from "For each program", "All programs", and "For each channel".

PRG : Applies individually to each program.

ALL : Applies uniformly to the entire programs.

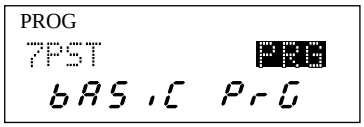
CH : Applies individually to each channel (for every 10 program).

(Initial setting: PRG)

Step 1: Each time the [∧] key is pressed, the selection item will change sequentially as follows:

PRG → ALL → CH

Step 2: If the [ENT] key is pressed while the target selection item is blinking, the current setup is accepted and the operation will automatically proceed to the next setting.



o. Setting the number of programs to be used (Guidance: PRGM)

Select the number of programs to be used from "100" and "10".

100 : 100 program mode

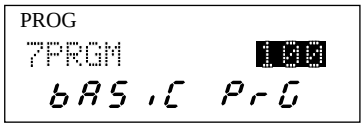
10 : 10 program mode

(Initial setting: 100)

Step 1: Each time the [∧] key is pressed, the selection item will change sequentially as follows:

100 → 10

Step 2: If the [ENT] key is pressed while the target selection item is blinking, the current setup is accepted and the operation will automatically proceed to the next setting.

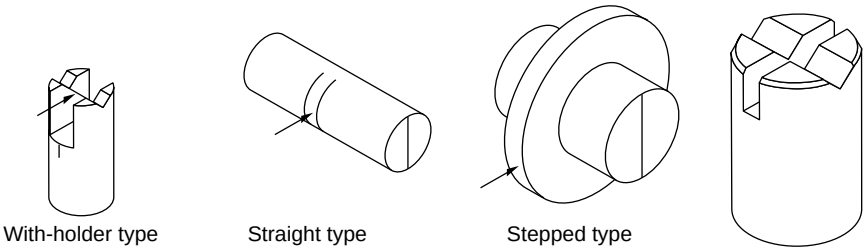


4.2 Calibration

The LSM system can be calibrated quite easily and with high accuracy.

4.2.1 Calibration gages and gage stand

Supported calibration gages and gage stand have the following shapes.



Calibration gages and stand

Gage stand

4.2.2 Entering the calibration mode

Enter the calibration mode with the following procedure.

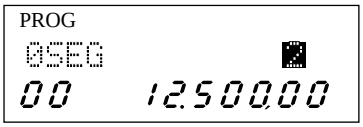
< Preparation >

(1) Turn on the power and wait at least 30 minutes for the system to thermally stabilize.

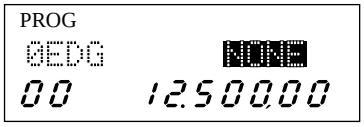
(2) Prior to use, wipe dust and oil from the gage and gage stand with a cloth soaked in alcohol or thinner. If calibration has been completed, carefully store them in a dedicated case after applying a rust preventive oil to their surfaces.

(3) Specify SEG 2.

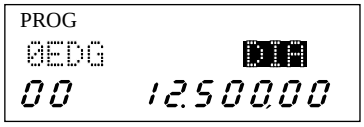
For information about the method of segment specification, refer to Section 4.5, “Setting Up the Functions”.



On edge specification, select either manual measurement or automatic measurement with respect to diameter.

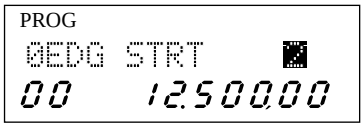


a) Manual measurement

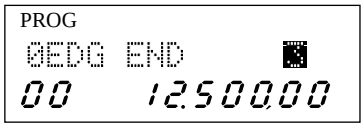


b) Automatic measurement

Set the start edge to 2 and the end edge to 3.



a) Start edge

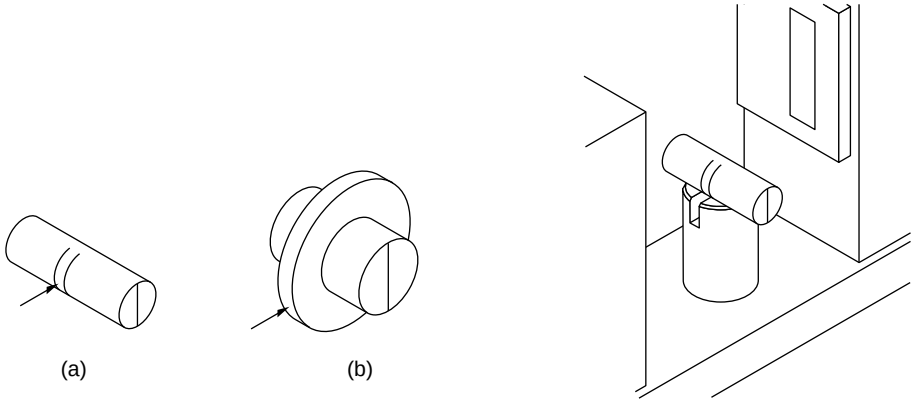


b) End edge

(4) Setting the HIGH CAL gage.

HIGH CAL gages vary in shape depending on the LSM model to be calibrated. Set the calibration gage so that the calibration guide line (|) on the side face of the calibration gage comes vertical, and so that the center of the calibrated section is measured.

In diagram (a), the calibrated position is at the center of the (| |) mark, and the center of the width (indicated by the arrow mark) in diagram (b).



Step 1: Cancel the previously set calibration values.

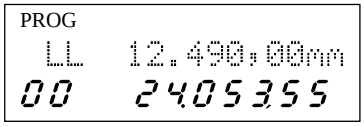
It is not necessary if this setup operation is made with the previously used calibration gage. However, if the new gage diameter is much different from that of the previous one, an error (Err-2) may result. If this is the case, cancel the LOW CAL calibration value, then begin with the setting of HIGH CAL value (it does not matter if both the LOW CAL and HIGH CAL values are canceled).

1) Cancel the previous LOW CAL data. Press the [L.CAL] key in the ready state to initiate the LOW CAL setup mode.

2) Press the [C] and [ENT] keys to cancel the LOW CAL data. This automatically restores the ready state.

[C]

[ENT]

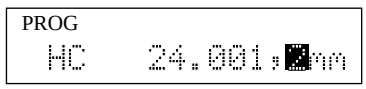


Step 2: Mount the HIGH CAL gage on the stand. Press the [H.CAL] key in the ready state. The previously set HIGH CAL value is displayed, and the HIGH CAL setup mode is entered.

Step 3: Enter the approved dimension of the HIGH CAL gage.

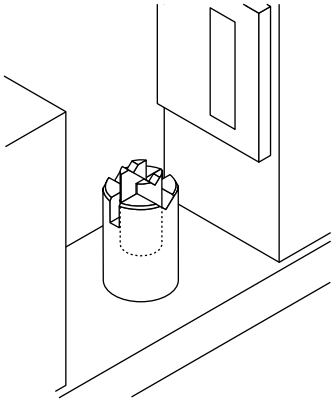
Example.)

[2] [4] [.] [0] [0] [1] [2]

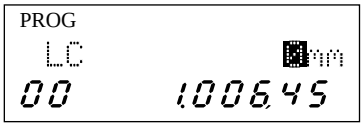


Step 4: If the [ENT] key is pressed to save the HIGH CAL setup value in memory, the operation automatically returns to the ready state.

Step 5: Set the LOW CAL gage.
As with the HIGH CAL gage, the LOW CAL gages vary in shape depending on the LSM model to be calibrated. Set the LOW CAL gage so that the center of the calibration range is properly measured.
A LOW CAL gage for calibrating dimensions less than 2 mm should be set so that it fits with the mounting hole of the gage stand.

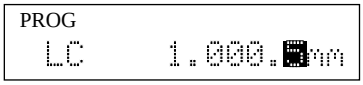


Step 6: Set up the LOW CAL gage.
In the ready state press the [L.CAL] key. The previously set LOW CAL value is displayed, and the LOW CAL setup mode is entered.

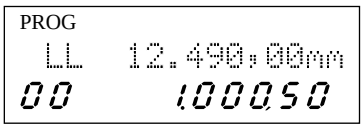


Step 7: Enter the verified dimension of the LOW CAL gage.

[1] [.] [0] [0] [0] [5]



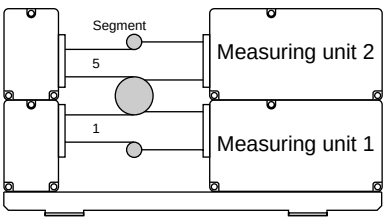
Step 8: If the [ENT] key is pressed to save the LOW CAL setup value in memory, the operation automatically returns to the ready state.



4.2.3 Combined calibration

For DF-type setup, it is possible to perform combined calibration with two Measuring Units.

In the example as shown at the right hand, a workpiece is mounted so it extends over two Measuring Units and a reference pins are used to improve the measurement repeatability.



In this case, a combination of segments (1 + 5) is used.

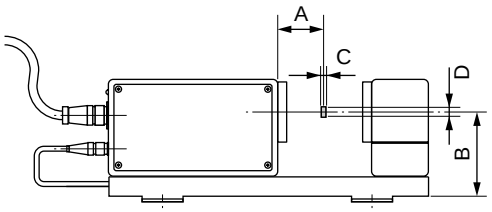
The method for setting up the calibration value is the same as that used for setting the HIGH CAL or LOW CAL gage.

IMPORTANT Calibration

1. Before performing a calibration, always perform the necessary setup for the resolution and dual-unit measurement. If this order is reversed, the set calibration value may be canceled and the measurement accuracy is not guaranteed.
2. Canceling the HIGH CAL value will also cancel the LOW CAL, offset, and mastering values.
3. With only a LOW CAL setup value the compensation calculation does not take place. This calculation will start when a HIGH CAL (or HIGH CAL and LOW CAL) value is set.
   If a HIGH CAL value is set, the CAL guidance (▼) will turn on in the display unit.
4. A calibration gage is important in that it is critical to the accuracy of the Measuring Unit. Wipe dust and oil from the gage with a cloth soaked in alcohol or thinner before using it.
   After use, apply a rust preventive oil to its surfaces and store it carefully in a dedicated case.
5. To confirm the HIGH CAL or LOW CAL setup value, press either the H.CAL or L.CAL key to enter each setup mode, and press the H.CAL (and SET) or L.CAL (and SET) key to exit to the ready state after the confirmation is over. Do not perform the setup operation in the confirmation process of the setup data.
6. On the user-supplied calibration gages, the dimensional ratio of a High CAL gage to a Low CAL gage should be greater than 1.2. Calibration performed with the calibration gages with diameters that are too close each other may reduce the measuring accuracy. The calibration gage should be the one which is made of the same or similar material as that of the workpiece. If a calibration gage of different material is used, error may be involved in measurement due to the difference in surface textures or properties.
7. For calibration measurement, no restriction exist for segment specification. If a gap or displacement needs to be precisely measured, a thickness gage can be used for calibration. (There will be a slight difference in measured data between those from OD and gap depending on the segment specified for calibration.)

4.3 Positioning a Gage or a Workpiece

1. Position the calibration gage or workpiece so that it is located at the middle of the measurement position.
   The shaded section in the following diagram is the measuring region where the rated measuring accuracy of this system is obtained.
2. The measured data is displayed even if a workpiece or a gage is located outside the measuring region, however, the measurement accuracy becomes worse than that of the guaranteed measurement accuracy.
3. Dimensions A, B, C, and D will vary depending on the Measuring Unit used. Refer to the specifications and dimensions described in the user's manual that comes with each Measuring Unit.

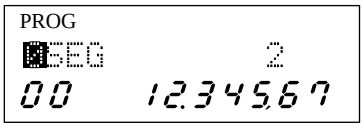


4.4 How to read-in the amount of light

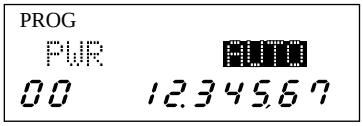
For measurement of the fine gap where the light passing through it can not be sufficiently secured it is necessary for the system to read-in the amount of light. For more information refer to Section 3.2.16, "Recording in the amount of light".

Step 1: Removal of obstructions
Remove any objects (workpiece and fixture) that obstruct the laser path before reading in the amount of light.

Step 2: Enter the function setup mode from the ready state.



Step 3: Press the SHIFT and READ keys while the function setup number is flashing to enter the light amount check mode.
Each time the ∧ key is pressed the setup option toggles between AUTO (automatic detection) and READ (reading in the amount of light).



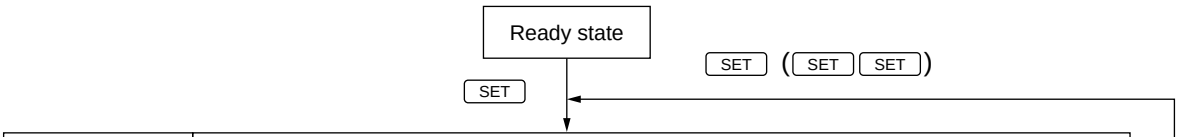
Step 4: Press the ENT key while READ is flashing.
If a sufficient amount of light is detected as a result of this positive check, the operation automatically returns to the ready state. If LOW is displayed, it indicates that the amount of light is insufficient. If this is the case, remove any obstruction and cancel the error with the C key, then perform step 4 again.

NOTE
- Conduct this operation two to three times a year to prevent a change in light intensity from affecting the measurements.
- Execute this operation as necessary if measurements are significantly affected by temperature drift.

4.5 Setting Up the Functions

Make measurement-related setups based on the conditions set in Section 4.1 “basic Setup”

4.5.1 Outline of the function setup mode



Function No.	Setup contents
F0	Setting the segment In the basic setup mode, first set whether the workpiece is an opaque or transparent object. If it is an opaque object, then it is possible to specify the number of segments and edges to be measured. With the edge specification a multiple-pin workpiece can be measured automatically. ◎ Segment specification: SEG (Opaque object: 1 to 7, Transparent object: 1 to 3) • Edge specification: EDG (Manual: NONE / Automatic: PIT / Automatic: DIA / Automatic: GAP) • Start edge : STRT (Between edge number 1 and 254) • Finish edge : END (Between edge number 2 and 255)
F1	Setting the measurement interval (measurement time) Note1 In the basic setup mode either of the two setting methods can be selected. ◎Arithmetical average: MR ARM (1 to 2048) • Moving average: MR MOV (32 to 2048)
F2	Setting the GO/NG judgment criteria In the basic setup mode either of the three setting methods can be selected. In addition, if the abnormal value elimination function will be specified, the limits (Lower abnormal limit: EL → Upper abnormal limit: EH → Abnormal value count: CNT) for this abnormal value elimination should be set prior to other setup items. ◎Lower limit : LL → Upper limit: LH • Multi-limit selection 1: L1 → Multi-limit selection 2: L2 → Multi-limit selection 3: L3 • • • • → Multi-limit selection 6: L6 Target value : NO → Lower tolerance limit: LO → Upper tolerance limit: UP
F3 Note2	Setting the reference value In the basic setup mode it is possible to copy the setup data of a target value to the reference value. If this is done the setup guidance for the reference value is not displayed. ◎Reference value: REF → Gain: SCL (1 to 3) • Gain: SCL (1 to 3)
F4	Setting the offset and mastering Both the offset and mastering can be set. ◎Offset: OFS → Direction: DIR (0 , 1) → Mastering: MST
F5	Setting the data output condition Data output condition: DAT O.C (0 to 9) : If 1, 3 or 5 is selected → Periodic data output: DAT TIM (0 to 999)

Function No.	Setup contents
F6	Setting the sample measurement [Note1] ◎ Number of sample workpieces: SMP N (0 to 999): The factory setting is [1]. → Calculation item: SMP ITM (See below for the calculation items choices.) [Choice]/"Mean: AVG ", "Maximum: MAX ", "Minimum: MIN ", "Range: RNG " "Odd-numbered-edge cutting tool outside diameter: TOOL D ", "Odd-numbered-edge cutting tool run-out: TOOL R " → Number of odd-numbered cutting edges: TOOL N (only when "Odd-numbered-edge cutting tool run-out" is selected.) [Remark] 1. Only when other than [1] is set for the "Number of sample workpieces", the guidance for "calculation item" will be displayed. 2. For "Odd-numbered-edge cutting tool outside diameter" and "Odd-numbered-edge cutting tool run-out", the guidance will be displayed only when "Odd-numbered-edge cutting tool measurement" is enabled with the "Basic setup".
F7 [Note2]	Setting automatic workpiece detection In the basic setup mode either detection by dimension or detection by position can be selected. If "Not performing the automatic workpiece detection" is selected, the setup guidance for the following option will not be displayed. Number of measurements: AUT N (0 to 999) → Invalidation period: AUT TIM (0 to 9999) → Detection lower limit: AUL → Detection upper limit: AUH
F8 [Note2]	Setting the group judgment In the basic setup mode setups for the group judgment can be made. If "Not performing the group judgment" is selected, the setup guidance for the following option will not be displayed. • Group size : GTJ N (0 ~ 99) → Statistical item: GTJ ITM (Average: GAG / Maximum value: GMX / Minimum value: GMN / Range: GRG) • Group lower limit value: GLL → Group upper limit value: GLH

◎Settings following the circle are factory settings.

• Settings following a dot are ones which have been selected in the basic setup.

Settings with no marking can be made in only one way.

NOTE 1: Measurement interval and the number of samples are automatically matched in simultaneous measurement.

NOTE 2: The function number may not be displayed depending on the basic setup contents.

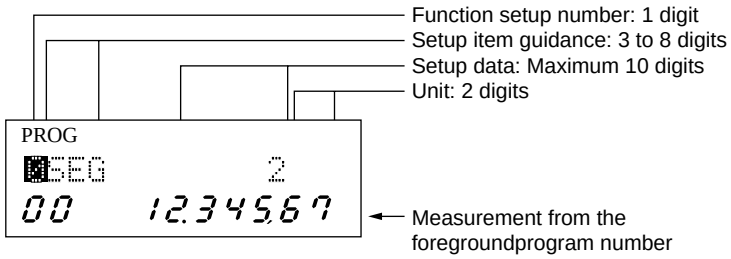
4.5.2 Outline of each function setup mode

1. Data display unit

   If the basic setup mode is entered, the following is displayed.

   The function setup number ▩ will be flashing in the most significant digit of the upper display section, and the guidance for the setup item, followed by the setup value, will be shown to the right of the setup number.

   In the lower display section the measurement from the foreground program number will be displayed.



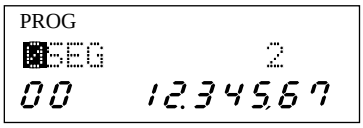
2. Setting each setup item
   - Use the numeric keys for setting the setup value, such as an preset value, and use the [∧] and [∨] keys for selecting the item, such as the statistical item of the sample measurement.
   - Press the [ENT] key to accept and save the setup data. After the setup content has been accepted, the operation automatically proceeds to the next setup item.

3. Setup values that must meet the large/small relationships
   The setup values for GO/NG judgment should meet the following relationships: Abnormal lower limit < Abnormal upper limit, Lower tolerance limit < Upper tolerance limit, and Lower limit value < Upper limit value.
   If the previously specified setup value needs to be modified to a great extent, it is recommended to first enter the new setup value thats meets the existing large/small relationship or, for safety, cancel the both sides to 0 then set them again.

4. Confirming the setup contents of each setup item
   To confirm the setup contents of each setup item use only the [ENT] key, which does not affect the setup contents.

5. Terminating the function setup mode
   - If the [SET] key is pressed while the function setup number is flashing, operation returns to the ready state.
   - If the [SET] key is pressed in the setup mode of each setup item, operation returns to the selection of a function setup number. If the [SET] key is pressed again at this point, operation returns to the ready state.
   - If the power is turned off halfway to the setup operation, on-going setup contents will not be saved in memory. The contents must be set again.

4.5.3 Function setup mode



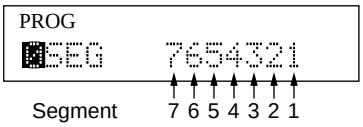
- If the function setup mode is entered using the [SET] key in the ready state, the function setup number 0 will be flashing as shown in the figure at the right.
- Each time the [∧] key is pressed when the function setup number is flashing, it will change as follows: 0 → 1 → 2 → 3 → 4 → 5 → 6 → 7 → 8 → 0. Press the [ENT] ([<]) key while the desired function setup number is flashing to enter the setup mode. If the [∨] key is pressed, this order will be reversed.
- If a key other than the [∧], [∨], [<], [ENT] and [SET] keys are pressed during the selection of a function setup number, an operation error will result.
- If each piece of setup data is accepted with the [ENT] key in the corresponding setup mode, the operation will automatically proceed to the next setup item.

4.5.3.1 F0: Setting the segment

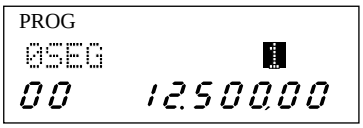
Use this function to set the measurement position (segment). The segment specification and edge specification methods are provided for this purpose. Both can be selected in the basic setup.

If this setup mode is entered, the previously established data will flash.

1) Segment specification
Places for displaying the segment numbers are fixed as shown in the figure at the right. In this example, set to SEG2.

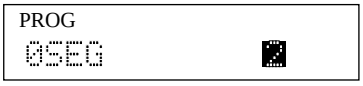


Step 1: If the segment setup mode is entered, the previously established data will be displayed.



Press the [2] key.

[2]



Step 2: Press the [ENT] key to save the setup data in memory.
Operation automatically proceeds to the measurement interval setting.

[ENT]

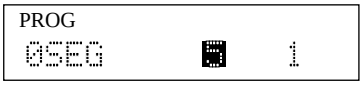
TIP Segment setup example

1. Set to segments (2 + 4).

[2] [4]

2. Set to segments (1 + 5).

[1] [5]



2) Edge specification

Step 1: If the edge specification mode is entered, the previously established manual measurement/ automatic measurement item will be displayed.

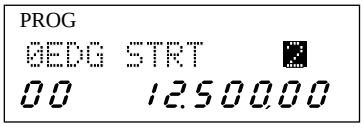
Each time the [∧] key is pressed the setup option changes in the following order: Manual measurement: NONE → Automatic measurement for pitch: PIT → Automatic measurement for diameter: DIA → Automatic measurement for gap: GAP. If the desired setup option is displayed, press the [ENT] key.

[∧]

Operation automatically enters the process of setting the start edge.

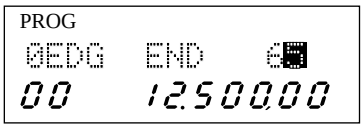
Step 2: Set the start edge (between number 1 and 254)
In this example, set the start edge to number 2.
If the [ENT] key is pressed, the operation automatically enters the process for setting the finish edge.

[2]



Step 3: Set the end edge (between number 2 and 255)
In this example, set the end edge to number 65.
If the [ENT] key is pressed, the operation automatically proceeds to F1: Setting the measurement interval.

[6] [5]



TIP

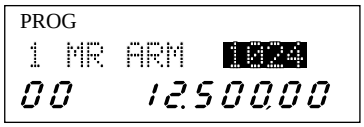
1. If a calibration is performed using the reference gage (placed in SEG2) with the edge specification active, select Manual measurement: NONE or Automatic measurement for diameter: DIA, then set the start edge to 2 and end edge to 3.
2. If the checks on the start and end edges, performed at the end of the setup operation, result in start edge > end edge, exchange the start and end edge data. If the check result shows that both edge numbers are identical, an error (Err-5) results. If this occurs, cancel the setup data and begin the setting with the start edge.

4.5.3.2 F1: Setting the measurement interval (measurement time)

Use this function to set the measurement interval. This measurement interval should be set according to the arithmetical average and moving average, whichever is specified in the basic setup.

1) Arithmetical average (Guidance: MR ARM)

Step 1: The previously set number of scans for averaging is displayed. Select between 1 and 2048 times . The relationship between the number of scans for averaging and measurement intervals are shown in the table below.



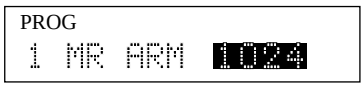
Relationship between the number of scans for averaging and measurement intervals (measurement times)

Number of scans for averaging	Measurement intervals (measurement time)		
	Arithmetical average	Moving average	
		1st measurement	2nd and subsequent measurements
1	0.00032 sec		–
2	0.00064 sec		–
4	0.0013 sec		–
8	0.0025 sec		–
16	0.005 sec		–
32	0.01 sec	0.01 sec	0.05 sec
64	0.02 sec	0.02 sec	0.05 sec
128	0.04 sec	0.04 sec	0.05 sec
256	0.08 sec	0.08 sec	0.05 sec
512	0.16 sec	0.16 sec	0.05 sec
1024	0.32 sec	0.32 sec	0.05 sec
2048	0.64 sec	0.64 sec	0.05 sec

Each time the [∧] key is pressed, the setup option changes in the following order: 1024 → 2048 → 1 → 2 → 4 → 8 → 16 → 32 → 64 → 128 → 256 → 512 → 1024. For this example select 1024 times.

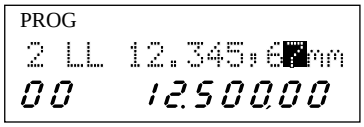
Select 1024 times.

[∨]



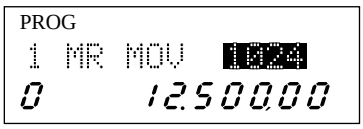
Step 2: Press the [ENT] key to save the setup data in memory.
The operation automatically proceeds to F2: Setting the GO/NG judgment criteria.

[ENT]



2) Moving average (Guidance: MR MOV)

Different in the setup guidance (MOV) and the number of scans for averaging (between 32 and 2048), however, the setup method is same with the arithmetical average.



NOTE

1. If “Performing ultra-fine wire measurement” is specified in the basic setup, between 16 and 2048 times should be selected.
2. A larger number of scans for averaging will improve the repeatability.
   If measuring time permits, set the greatest number of scans for averaging possible.
3. If the number of scans for averaging is set to between 1 and 4, the scan signals will be thinned for the measurement. This results in a measurement interval of 0.002 to 0.003 second.

4.5.3.3 F2: Setting the GO/NG judgment criteria

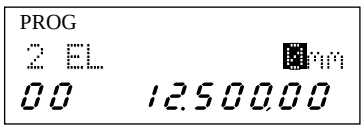
Set the GO/NG judgment criteria according to the tolerance judgment method: (Lower limit value + Upper limit value), (Multi-stage selection: 7 stages), and (Target value + tolerance), whichever is specified in the basic setup. If "Using the abnormal value elimination function" has been specified, the abnormal limit values should be set prior to setting the GO/NG judgment criteria.

In this example assume that the machining target value is 12.5 $^{+/- 0.01}$ mm, and that all the abnormal limits (lower and upper) and GO/NG judgment criteria are canceled (set to 0).

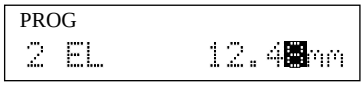
1) Setting the abnormal limit values

Set as follows: Lower abnormal limit = 12.48 mm, Upper abnormal limit = 12.52 mm, Abnormal value count = 3.

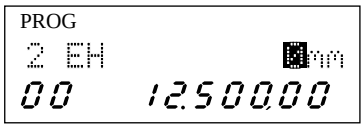
Step 1: The previously set lower abnormal limit is displayed.
Enter "12.48".



1 2 . 4 8

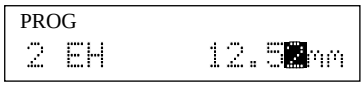


Step 2: Press the ENT key.
The setup data will be saved in memory and operation automatically proceeds to the setting for the upper abnormal limit.

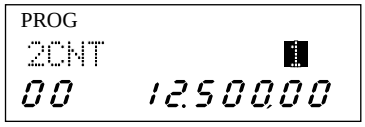


Step 3: Enter "12.52", which is the setup data for the upper abnormal limit.

1 2 . 5 2



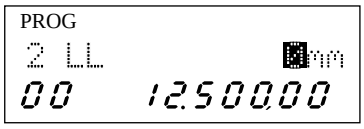
Step 4: Press the ENT key.
The setup data will be saved in memory and operation automatically proceeds to the abnormal value count setting.



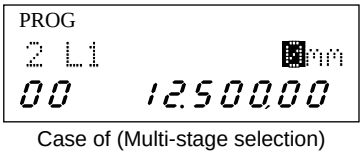
Step 5: Enter "3", which is the setup data for the abnormal value count.

3

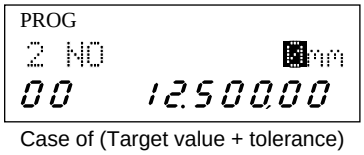
Step 6: Press the ENT key.
The setup data will be saved in memory and operation will automatically proceed to the GO/NG judgment criteria setting.
The method of GO/NG judgment varies with the contents of the basic setup.



Case of
(Lower limit value and Upper limit value)



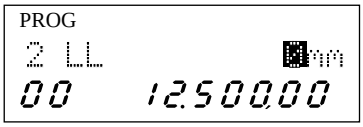
Case of (Multi-stage selection)



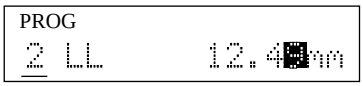
Case of (Target value + tolerance)

2) GO/NG judgment criteria setting (by "Lower limit value and upper limit value")
In this example assume that the lower limit value is 12.49 mm and that the upper limit value is 12.51 mm.

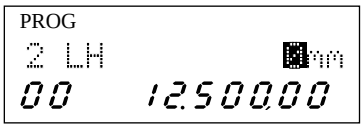
Step 1: The previously set lower limit value is displayed. Enter "12.49".



1 2 . 4 9

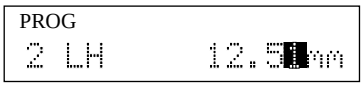


Step 2: Press the ENT key.
The setup data will be saved in memory and the operation automatically proceeds to the upper limit value setting.

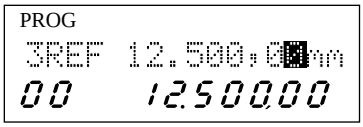


Step 3: Enter "12.51", which is the setup data for the upper limit value.

1 2 . 5 1



Step 4: Press the ENT key.
The setup data will be saved in memory and the operation automatically proceeds to the reference value setting.

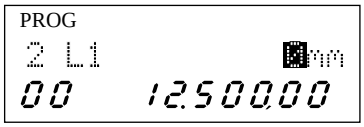


3) Setting the GO/NG judgment criteria (by multi-limit selection)

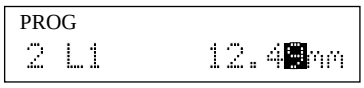
In this example assume the following:

L1=12.49mm
L2=12.494mm
L3=12.498mm
L4=12.502mm
L5=12.506mm
L6=12.51mm

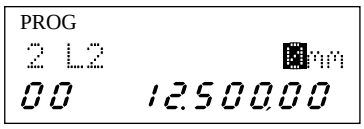
Step 1: The previously entered setup value for L1 is displayed.
Enter “12.49”.



1 2 . 4 9

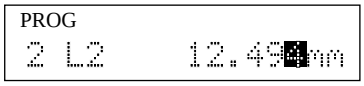


Step 2: Press the ENT key.
The setup data will be saved in memory and the operation automatically proceeds to the L2 setting.

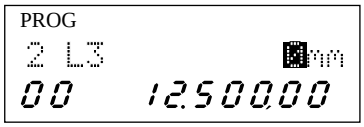


Step 3: Enter “12.494”, which is the setup data for L2.

1 2 . 4 9 4

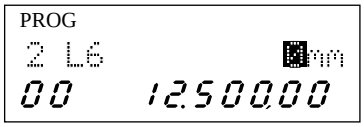


Step 4: Press the ENT key.
The setup data will be saved in memory and the operation automatically proceeds to the L3 setting.



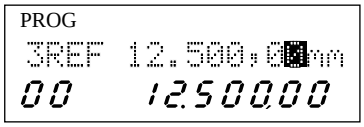
Step 5: As with L1 and L2, set L3, L4, and L5.

Step 6: Enter “12.51”, which is the L6 setup value.



1 2 . 5 1

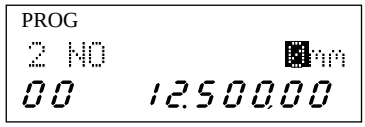
Step 7: Press the ENT key.
The setup data will be saved in memory and the operation automatically proceeds to the reference value setting.



4) Setting the GO/NG judgment criteria (with "Target value + tolerance")

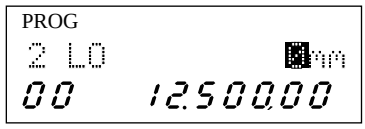
In this example assume that the target value is 12.5 mm, lower tolerance is -0.01 mm, and upper tolerance is 0.01 mm.

Step 1: The previously set target value is displayed.
Enter "12.5".



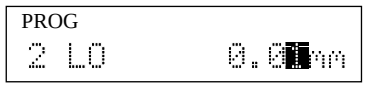
[1] [2] [.] [5]

Step 2: Press the [ENT] key.
The setup data will be saved in memory and the operation automatically proceeds to the lower tolerance value setting.
The target value will be automatically copied on the reference value, if so set in the basic setup, and if any scale value was not set, it will be set to 1.



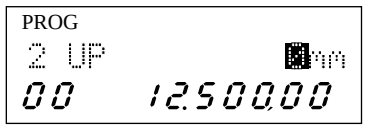
Step 3: Enter "0.01", which is the lower tolerance value, and a negative sign.

([0]) [.] [0] [1]



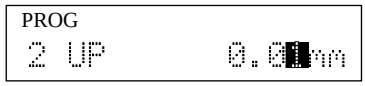
[+/-]

Step 4: Press the [ENT] key.
The setup data will be saved in memory and the operation automatically proceeds to the upper tolerance value setting.

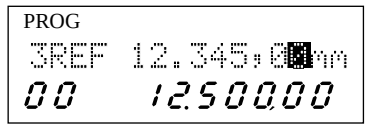


Step 5: Enter "0.01", which is the upper tolerance value.

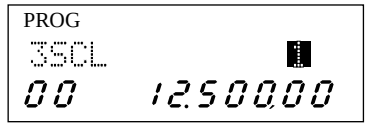
([0]) [.] [0] [1]



Step 6: Press the [ENT] key.
The setup data will be saved in memory and the operation automatically proceeds to the reference value setting.
The displayed guidance for the setup item will vary depending whether "Copying the target value to the reference value" has been specified in the basic setup.



When not copying the target value to the reference value.



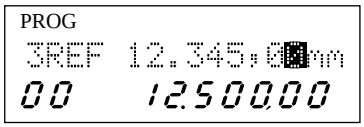
When copying the target value to the reference value.

4.5.3.4 F3: Setting the reference value

Set the reference value and/or scale value here. If “Copying the target value to the reference value” has been specified in the basic setup, the setup guidance for the reference value will not be displayed, however, setting the scale value is permitted.

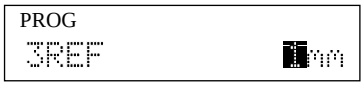
In this example assume that the reference value is 12.5 mm, and the scale value is 1.

Step 1: The previously set reference value is displayed. Enter “12.5”.



If “1” is entered the currently displayed setup value changes to “1”, however, it will not be saved in memory until the [ENT] key is pressed.

[1]



Enter “2”.

[2]

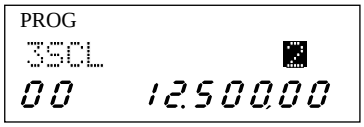
Enter a decimal point (“.”).

[.]

Enter “5”.

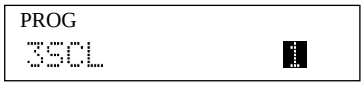
[5]

Step 2: Press the [ENT] key.
The setup data will be saved in memory and the operation automatically proceeds to the scale value setting.

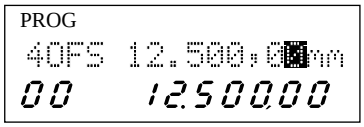


For information about the relationship between the analog voltage output and scale value, refer to Section 4.5.3.5, “Analog voltage output and scale value”.

Enter a scale value of “1”.



Step 3: Press the [ENT] key.
The setup data will be saved in memory and the operation automatically proceeds to the offset value setting.



4.5.3.5 Analog voltage output and scale value

The analog voltage output is determined from (Measured data - reference value) x scale value (gain), and therefore varies depending on the resolution set on each Measuring Unit, as shown in the following table.

Table 1: Metric units (The upper limit of the analog output must be within the range of actual measurements)

Scale value (1)		Minimum readout on the display unit			
Number		0.01µm	0.02µm	0.05µm	0.1µm
1	Resolution	2.5mV/0.01µm	2.5mV/0.02µm	2.5mV/0.05µm	2.5mV/0.1µm
	Maximum output	±5V/20µm	±5V/40µm	±5V/100µm	±5V/200µm
2	Resolution	2.5mV/0.1µm	2.5mV/0.2µm	2.5mV/0.5µm	2.5mV/1µm
	Maximum output	±5V/200µm	±5V/400µm	±5V/1mm	±5V/2mm
3	Resolution	2.5mV/1µm	2.5mV/2µm	2.5mV/5µm	2.5mV/10µm
	Maximum output	±5V/2mm	±5V/4mm	±5V/10mm	±5V/20mm

Scale value (2)		Minimum readout on the display unit			
Number		0.2µm	0.5µm	1µm	2µm
1	Resolution	2.5mV/0.2µm	2.5mV/0.5µm	2.5mV/1µm	2.5mV/2µm
	Maximum output	±5V/400µm	±5V/1mm	±5V/2mm	±5V/4mm
2	Resolution	2.5mV/2µm	2.5mV/5µm	2.5mV/10µm	2.5mV/20µm
	Maximum output	±5V/4mm	±5V/10mm	±5V/20mm	±5V/40mm
3	Resolution	2.5mV/20µm	2.5mV/50µm	2.5mV/100µm	2.5mV/200µm
	Maximum output	±5V/40mm	±5V/100mm	±5V/200mm	±5V/400mm

Scale value (3)		Minimum readout on the display unit		
Number		5µm	10µm	100µm
1	Resolution	2.5mV/5µm	2.5mV/10µm	2.5mV/100µm
	Maximum output	±5V/10mm	±5V/20mm	±5V/200mm
2	Resolution	2.5mV/50µm	2.5mV/100µm	2.5mV/1mm
	Maximum output	±5V/100mm	±5V/200mm	±5V/2000mm
3	Resolution	2.5mV/500µm	2.5mV/1mm	2.5mV/10mm
	Maximum output	±5V/1000mm	±5V/2000mm	±5V/20000mm

Table 2: Inch unit (E=25.4 mm) (The upper limit of the analog output must be within the range of actual measurements)

Scale value (1)		Minimum readout on the display unit			
Number		.000001E	.000002E	.000005E	.00001E
1	Resolution	2.5mV/.000001E	2.5mV/.000002E	2.5mV/.000005E	2.5mV/.00001E
	Maximum output	±5V/.002E	±5V/.004E	±5V/.01E	±5V/.02E
2	Resolution	2.5mV/.00001E	2.5mV/.00002E	2.5mV/.00005E	2.5mV/.0001E
	Maximum output	±5V/.02E	±5V/.04E	±5V/.1E	±5V/.2E
3	Resolution	2.5mV/.0001E	2.5mV/.0002E	2.5mV/.0005E	2.5mV/.001E
	Maximum output	±5V/.2E	±5V/.4E	±5V/1E	±5V/2E

Scale value (2)		Minimum readout on the display unit			
Number		.00002E	.00005E	.0001E	.0002E
1	Resolution	2.5mV/.00002E	2.5mV/.00005E	2.5mV/.0001E	2.5mV/.0002E
	Maximum output	±5V/.04E	±5V/.1E	±5V/.2E	±5V/.4E
2	Resolution	2.5mV/.0002E	2.5mV/.0005E	2.5mV/.001E	2.5mV/.002E
	Maximum output	±5V/.4E	±5V/1E	±5V/2E	±5V/4E
3	Resolution	2.5mV/.002E	2.5mV/.005E	2.5mV/.01E	2.5mV/.02E
	Maximum output	±5V/4E	±5V/10E	±5V/20E	±5V/40E

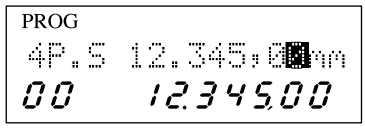
Scale value (3)		Minimum readout on the display unit	
Number		.0005E	.005E
1	Resolution	2.5mV/.0005E	2.5mV/.005E
	Maximum output	±5V/1E	±5V/10E
2	Resolution	2.5mV/.005E	2.5mV/.05E
	Maximum output	±5V/10E	±5V/100E
3	Resolution	2.5mV/.05E	2.5mV/.5E
	Maximum output	±5V/100E	±5V/1000E

4.5.3.6 F4: Setting the preset/zero-set values

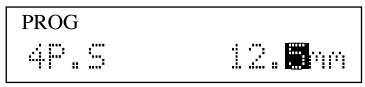
1) Set the preset value and/or mastering value here.

In this example assume that the preset value is 12.5 mm, the direction is 0 (positive), and the mastering value is 0.0. Assume also that the current preset value is 12.345 mm.

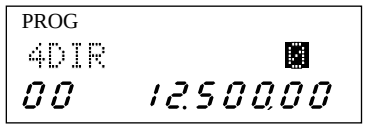
Step 1: The previously set preset value is displayed.
Enter “12.5”.



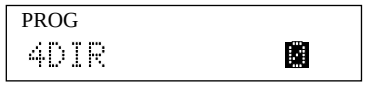
1 2 . 5



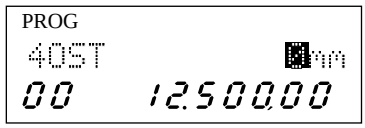
Step 2: Preset guidance (▼) turns on and the setup data will be saved in memory and the operation automatically proceeds to the direction setting.



Step 3: Set the direction to “0”.
Since in this example the previous setting is “0”, it is not necessary to enter the same value again. However, if there is a need to change the direction to “1”, enter “1”.



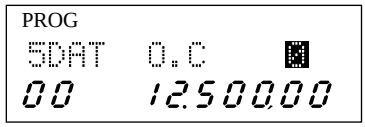
Step 4: Press the ENT key.
The setup data will be saved in memory and the operation automatically proceeds to the mastering value setting.



Step 5: Enter “0.0”, which is the mastering value.

0 . 0

Step 6: Press the ENT key.
The setup data will be saved in memory and the operation automatically enters the data output condition setting.



2) Setting the Zero-Set

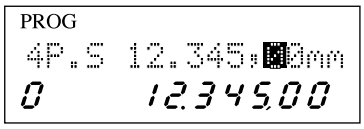
Press the 0 key at step 1 in 1). Follow the same procedures described in 1).

3) Canceling Preset/Zero-set

Press the C key at step 1 in 1). Then, press the ENT key.
Preset/Zero-Set is canceled and the setting mode of data output condition setting is automatically entered.

NOTE How to use the preset function

1. To obtain an preset value, it is necessary to set up the reference gage in place (the preset value is a compensation value determined from the measurement of the reference gage). This preset setup takes about 1 second.
2. If the existing setup value is applied, it is not necessary to carry out the preset. To force the preset operation using the same data, move the highlighted digit place with the [<] key. This makes the preset carried out, since the system judges the data is changed.
   For this operation press the [P.SV/P.SET] key in the ready state. With this single key operation preset will be carried out.



3. So that the maximum displayable range is not exceeded during measurement, the preset value must be set well within the maximum value shown in the table below. If measured data exceed the maximum value, “9999999” will be displayed.

Resolution (μm)	Maximum value (mm)
0.01/0.02/0.05	±89.99999
0.1/0.2/0.5	±899.9999
1/2/5/10/100	±8999.999

Resolution (E)	Maximum value (E)
.000001/.000002/ .000005	±8.999999
.00001/.00002/.00005/ .0001/.0002/.0005/.005	±89.99999

4. Precautions prior to modifying the unit system
   Note that if an preset value exceeds the above described maximum value when the unit system is changed from E to metric, the preset function will automatically be reset.
   (Example: If the integer part of the maximum value is restricted to 2 digits, converting from 4E to 101.6 mm will exceed the limit.)
5. To use the combined preset function together with the combined calibration function for dual-unit measurement of a DF-type setup, set the direction to “0” (positive).
6. Preset setting is also possible with the following key entry: [SHIFT], [P.SV/P.SET], (gage size), and [ENT].
7. If [P.SV/P.SET] is entered in the ready state, zero-setting will be performed if no preset has been made.
8. Preset/Zero-set can also be canceled with the following key entry: [SHIFT], [P.SV/P.SET], [C], and [ENT].

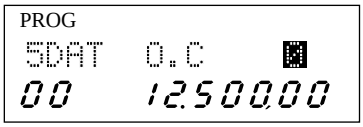
4.5.3.7 F5: Setting the data output conditions

Set the data output conditions (0 to 9) and periodical output timer (0 to 999 sec).

The unit used with the periodical output timer is seconds. Setting it to "0" means that output takes place for each measurement.

In this example assume that the data output condition is 3 and that the periodical output timer is 10 seconds.

Step 1: The previously set data output conditions are displayed.
The setup data for the data output conditions is shown in the table below.



Data output condition	RS-232C GP-IB DCU	Printer	Remark
0			
1		○	The periodical output timer can be set
2		△	
3	○		The periodical output timer can be set
4	△		
5	○	○	The periodical output timer can be set
6	△	△	
7		□	
8	□		
9	□	□	

○ : Outputted for each measurement if DATA C/RUN or C.RUN key, etc., is pressed.
△ : Press the DATA C/RUN or C.RUN key to trigger the measurement. The measurement result will be outputted if it falls on GO.
□ : Press the DATA C/RUN or C.RUN key to trigger the measurement. The result will be outputted if it falls on –NG.
: No output will be made.

Enter "3" as the data output condition.

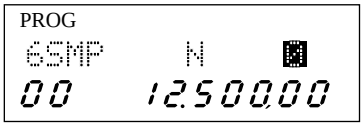
[3]

Step 2: Press the [ENT] key.
If the data output condition is 1, 3, or 5, the operation proceeds to the periodical output timer setting, otherwise it proceeds to the sample measurement setting.

Step 3: Set the periodical output timer to 10 seconds.

[1] [0]

Step 4: Press the [ENT] key to save the setup data in memory.
The operation enters the sample measurement setting.



4.5.3.8 F6: Setting the sample measurement

Set the conditions for the sample measurement here.

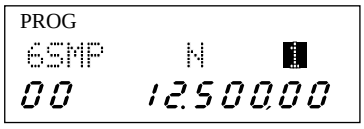
1. Where “Odd-numbered-edge cutting tool measurement function” has been set to “Disable (NONE)” in the Basic setup.

For this sample measurement use single-run measurement or continuous-run measurement, and select either 0, 1 , or 2 to 999 samples.

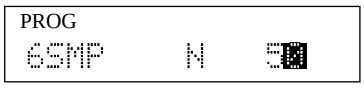
Number of samples	Single-run measurement	Continuous-run measurement
0	Called "zero-run measurement". Measurement is initiated by pressing the key assigned to single-run measurement, and measurement continues until the same key is pressed again. The result of the specified statistical item will be displayed as it is latched on the display.	Does not function (causes an input error).
1	The sample measurement does not take place, but a normal single-run measurement does.	The sample measurement does not take place, but a normal continuous-run measurement does.
2~999	The specified number of samples are measured and the result of the specified statistical item will be displayed as it is latched on the display.	The single-run measurement described at the left will be repeated.

In this example assume that the number of samples is 50, and the statistical item is range.

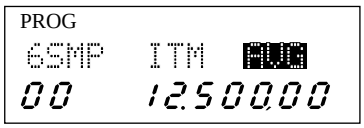
Step 1: The previously set number of samples flashes.



Enter “50” as the number of samples. (5) (0)

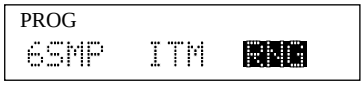


Step 2: Press the (ENT) key.
If the number of samples entered is “1”, the operation proceeds to the automatic workpiece detection setting, otherwise if “0” or “2 to 999” is entered, it proceeds to the statistical item setting.

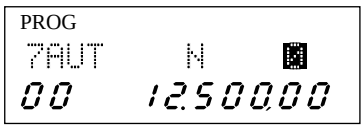


Step 3: Select the objective statistical item. Each time the (∧) key is pressed, the setup option changes in the following order: AVG → MAX → MIN → RNG. Select RNG in this example.

(∨) (∧ ∧ ∧)



Step 4: Press the (ENT) key.
The operation automatically proceeds to the automatic workpiece detection setting.

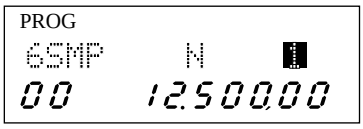


2. Where "Odd-numbered-edge cutting tool measurement function" has been set to "Enable (USE-1 or USE-2)" in the Basic setup.

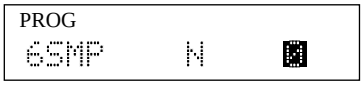
In this section only the setup operation is described. For the practical measurement samples refer to Section 5.3.6 "Application of the odd-numbered-edge cutting tool measurement".

In this example assume that Number of samples =0, Calculation item = "Odd-numbered-edge cutting tool measurement", and Number of odd-numbered cutting edges = 3.

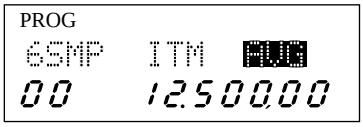
Step 1: The number of samples that has been already set will be blinking.



Enter "0" as the number of samples.



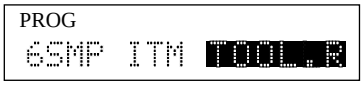
Step 2: When [ENT] is entered, the setting will be accepted and the operation will proceed to the setting of workpiece automatic detection if the set number of samples is "1", and to the setting of calculation items if the set number of samples is "0", or "2 to 999".



Step 3: Select the calculation item. The following calculation items will be added to in the place of "AUT, MAX, MIN, RNG".

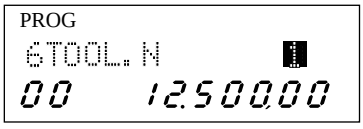
TOOL.D : Odd-numbered-edge cutting tool diameter measurement

TOOL.R : Odd-numbered-edge cutting tool run-out measurement



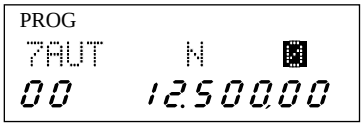
As each time [∧] is entered the displayed item will sequentially change as AUT → MAX → MIN → RNG → TOOL.D → TOOL.R, select TOOL.R.

Step 4: When [ENT] is entered, the setting will be accepted. At this time the operation will enter the setting of workpiece automatic detection if AUT, MAX, MIN, RNG, TOOL.D is selected for the calculation item, or the setting of the number of cutting edges of odd-numbered-edge cutting tool if TOOL.R is selected for the calculation item.



Enter "3" as the number of cutting edges of the odd-numbered-edge cutting tool.

Step 5: When [ENT] is entered, the setting will be accepted, and the operation automatically proceeds to the setting of workpiece automatic detection.



NOTE Where "TOOL.D:Odd-numbered-edge cutting tool diameter measurement" or "TOOL.R:Odd-numbered-edge cutting tool run-out measurement" has been selected for the calculation item, available segments will be automatically set and the guidance (SEG) for setting the segments will be displayed hereafter.

4.5.3.9 F7: Automatic workpiece detection setting

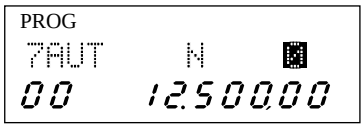
Set the conditions for automatic workpiece detection here.

Select between 0 (no automatic workpiece detection) and 999 measurements, and select between 0 to 9999 ms for the invalidation period.

In this example assume the following:

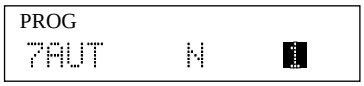
Number of measuring times =1, Invalidation period = 100 ms (0.1 sec), Lower detection limit = 12.2 mm, Upper detection limit = 12.8 mm.

Step 1: The previously set data output condition is flashing.

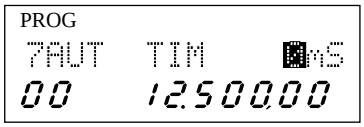


Enter “1” as the number of measurements.

[1]

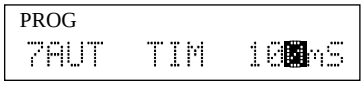


Step 2: Press the [ENT] key.
The operation automatically proceeds to the invalidation period setting.

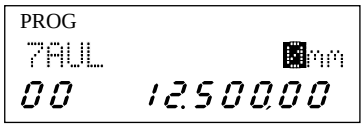


Step 3: Set the invalidation period to 100 ms.

[1] [0] [0]

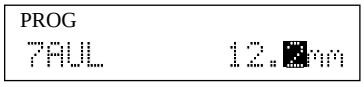


Step 4: Press the [ENT] key.
The operation automatically proceeds to the lower detection limit setting.

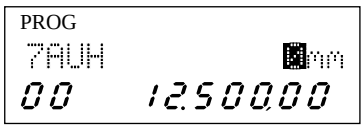


Step 5: Set the lower detection limit to 12.2 mm.

[1] [2] [.] [2]



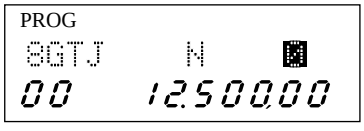
Step 6: Press the [ENT] key.
The operation automatically proceeds to the upper detection limit setting.



Step 7: Set the upper detection limit to 12.8 mm.

[1] [2] [.] [8]

Step 8: Press the [ENT] key.
The operation automatically proceeds to the group judgment setting.



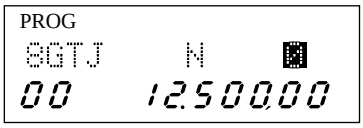
4.5.3.10 F8: Setting the group judgment

Set the conditions for the group judgment here.

Select between 0 and 99 for group size (0 and 1 are used for not performing group judgment).

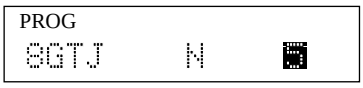
In this example assume that the group size is 5, and the objective statistical item is mean.

Step 1: The previously set group size is flashing.

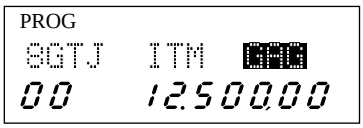


Enter "5" as the group size.

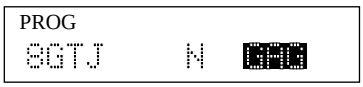
[5]



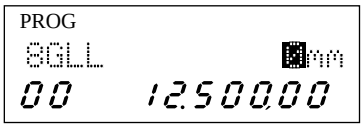
Step 2: Press the [ENT] key.
If 0 or 1 is set for the group size in step 1 above, the operation automatically proceeds to the segment setting, which is the first stage of this function setup. Otherwise proceeds to the statistical setting.



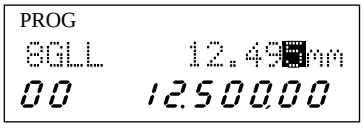
Step 3: Select the objective statistical item, Each time the [∧] key is pressed, the setup option will change in the following order: MEA → MAX → MIN → RNG. Since "mean" is to be set in this example, no key input is necessary at this step.



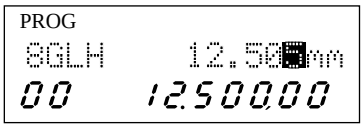
Step 4: Press the [ENT] key.
The operation automatically proceeds to the group lower limit setting.



Step 5: Set the group lower limit in the manner similar to that of the lower limit setting. Press the [ENT] key and the operation automatically proceeds to the group upper limit setting.



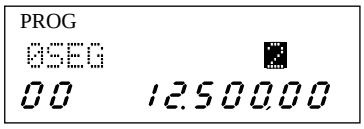
Step 6: Set the group upper limit in the manner similar to that of the upper limit setting. Press the [ENT] key and the operation automatically proceeds to the segment setting, which is the first stage of this function setup.



4.5.3.11 Confirming the function setup contents

Every setting that has been made in the function setup mode can be confirmed using the ENT key without affecting the existing setup data.

Step 1: In the ready state press the SET and ENT keys to enter the segment setup mode.



Step 2: Each time the ENT key is pressed, each piece of setup data for segments through group judgment will be displayed sequentially. Record these data in the List of Function Setups, at the end of this user's manual.

Step 3: Press the SET key twice to return to the ready state.

5 MEASUREMENT MODE

Perform your measurement according to the basic setup and measuring conditions specified.

This chapter describes the items which can be set in the ready state and gives measurement examples.

5.1 Outline of the Measurement Mode

The measurement mode includes the ready state, single-run measurement mode, and continuous-run measurement mode.

1) Ready state
The BUSY LED flashes each time the measurement is performed.

2) Single-run measurement
The RUN LED stays lit from the start of measurement until the display latch timer expires, and the BUSY LED turns on each time the measured data is updated.

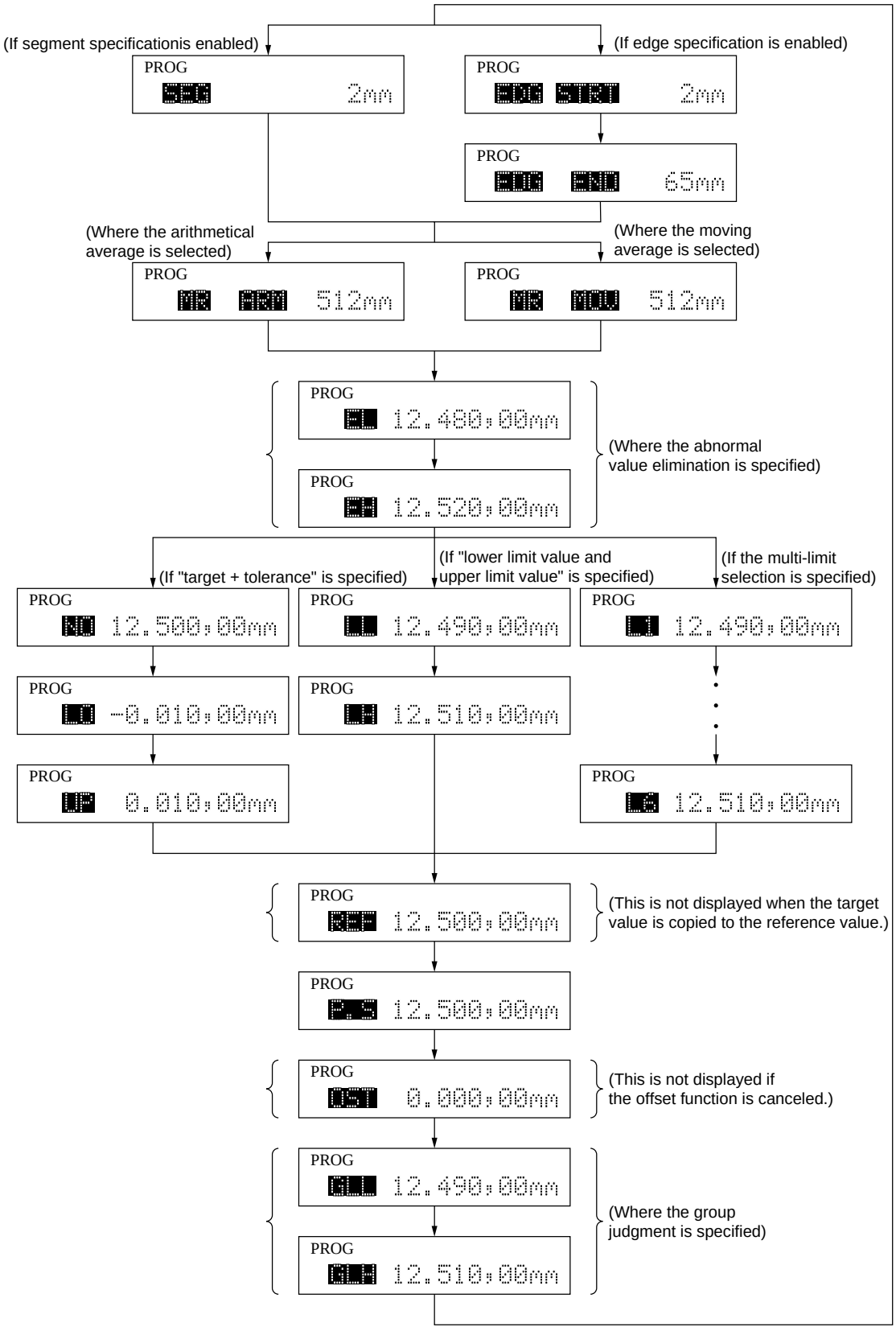
3) Continuous-run measurement
The RUN LED turns on if measurement starts and stays on during repeated measurements. The BUSY LED turns on each time the measured data is updated. When measurement is terminated the measured data is latched on the display and the RUN LED turns off when the display latch time expires.

5.1.1 Settings made in the measurement mode

- This system employs a 2-section display unit, which enables continuous display of setup values while measurements are being made. Also, it provides a simple method for modifying the setup values.
- The setup mode of the specific setup items can be entered either by using the arrow key ([<]) or by pressing the corresponding item keys directly.

5.1.1.1 Setup operation from the arrow key

If the < key is pressed in the ready state, the setup operation will progress in the following way. The displayed contents will vary depending on the basic setup.



• The setting procedure is as follows:

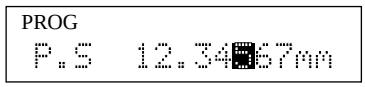
Step 1: Press the [<] key in the ready state to enter the setup mode.

Step 2: Each time the [∧] key is pressed, the setup guidance for each setup item changes in the following order: [redacted] ([redacted] → [redacted]) → [redacted] ([redacted] → [redacted]) → [redacted] → [redacted] ([redacted] → • • • [redacted] or [redacted] → [redacted] → [redacted]) → ([redacted]) → [redacted] → ([redacted]) → ([redacted] → [redacted]). Press the [ENT] key when the desired setup option is flashing. Press the [∨] key to reverse this order.

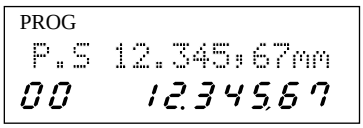
Step 3: Modify the setup data. The method used to enter data is the same as that used in the function setup mode.
For practice, modify the preset value from 12.5 mm to 12.34567 mm.
The previously set data is displayed and its least significant digit is flashing.

Enter “12.34567”.

[1] [2] [.] [3] [4] [5] [6] [7]

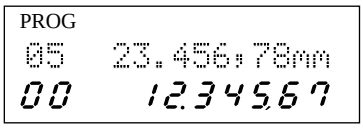


Step 4: Press the [ENT] key to initiate the following operation flow: Measure a reference gage, execute the compensation calculation, save the setup data in memory, then return to the ready state.
If the insertion of a comma after the thousandth digit has been specified in the basic setup, the comma will be automatically inserted.



(In single measurement)

For a single measurement the most recent setup item will always be displayed in the upper section of the display unit. However, the upper section of the display unit shows a background measurement in the simultaneous measurement.



(In simultaneous measurement)

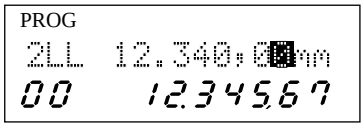
TIP

1. In simultaneous measurement the upper section of the display unit shows a background measurement. However, the setup mode for the foreground program can be entered by pressing the [<] key.
2. In single measurement, if an important setup item being displayed in the upper section of the display unit is retained, confirmation of the measuring object and modification of the setup data is easy.
3. If the [SET] key is pressed halfway in the setup operation, the operation is suspended and the ready state is restored. This can be used to confirm the setup data.
4. The last setup item made will be displayed first.

5.1.1.2 Setup that can be made directly from each setup item key

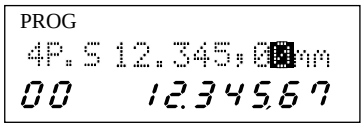
The user can enter the specific setup mode by pressing the corresponding setup item key in the ready state.

1) [LIMIT] key



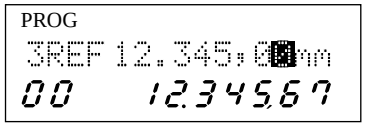
This key is used to enter the setup mode for only the GO/NG judgment function.
If the [ENT] key is pressed after the setup data is entered, the set up data will be saved in memory and operation will return to the ready state. If the [LIMIT] key or [SET] key is pressed halfway in the setup operation, the setup operation is aborted, and operation returns to the ready state.

2) [SHIFT] + [P.SV/P.SET] key



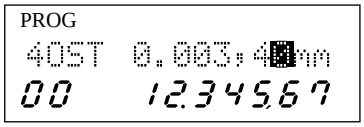
Enters the setup mode only for presetting.
As soon as the setup data is saved in memory with the procedure of "Entry of setup data" → [ENT], the presetting takes place and then the operation returns to the stand-by state.If the [P.SV/P.SET] key or [SET] key is pressed halfway in the setup operation, the setup operation is aborted, and operation returns to the ready state.

3) [MASTER/REF] key



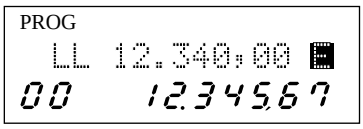
This key is used to enter the setup mode for only the reference value and scale value.
If the [ENT] key is pressed after the setup data is entered, the setup data will be saved and the operation will return to the ready state. If the [REF] key or [SET] key is pressed halfway in the setup operation, the setup operation is aborted, and operation returns to the ready state.

4) [SHIFT] + [MASTER/REF] key



This key combination is used to enter the setup mode for only the mastering function.
If the [ENT] key is pressed after the setup data is entered, the set up data will be saved in memory and operation will return to the ready state. If the [MASTER/OFFSET] key or [SET] key is pressed halfway in the setup operation, the setup operation is aborted, and operation returns to the ready state.

5) LOCK/UNIT key



This key is used to enter the modification mode of the unit of measurement. If the metric unit is currently being used, E will be flashing; and if the E unit is currently being used, mm will be flashing.

If the ENT key is pressed, the unit is changed to that which is currently flashing, then operation returns to the ready state.

If the LOCK/UNIT key or SET key is pressed halfway in the setup operation, the setup operation is aborted, and operation returns to the ready state.

The metric to E (1 E = 25.4 mm) conversion table is shown below.

mm	0.00001	0.00002	0.00005	0.0001	0.0002	0.0005
E	.000001 *	.000001	.000002	.000005	.00001	.00002

mm	0.001	0.002	0.005	0.01	0.1	–
E	.00005	.0001	.0002	.0005	.005	–

Note 1: Theoretically, conversion of a value with an asterisk ("*") into the E system results in a value of .0000005. On this LSM, the value will be converted into a resolution of .000001.

Note 2: For information about the resolutions that can be selected for each Measuring Unit refer to Section 4.1.2.1, "Selecting and setting the function in the B0 mode".

5.2 Other Functions

From the ready state it is possible to activate the following modes.

5.2.1 Key lock

Press the SHIFT and LOCK/UNIT keys to activate the key lock mode. Subsequently, key operations other than SHIFT and LOCK/UNIT keys will not be accepted. To cancel this mode, press the same keys again.

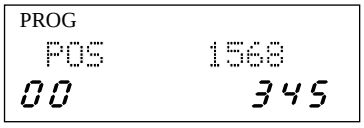
However, if the key lock mode is initiated by the "LOCK" command from the RS-232C/GP-IB interface, it can not be canceled by any key operation.

The only way the key lock mode is canceled is by turning the power off.

5.2.2 Displaying the measuring position

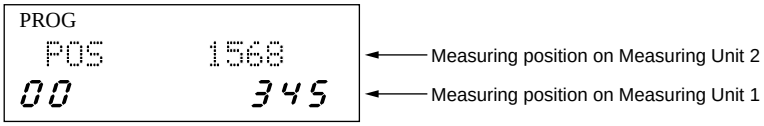
- If the SHIFT and READ keys are pressed in the ready state, the measuring position (focal position) display mode is entered. The ready state can be returned to if the READ key or SET key is pressed.

(One Measuring Unit)

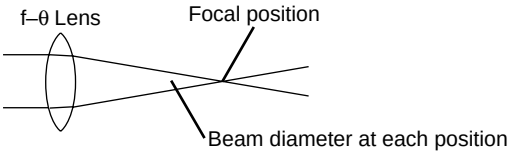


(Two Measuring Unit)

- The displayed value is not defined, but a value that is proportional to the beam diameter at the measuring position.
  Since the measurement is defined at the focal position where the displayed value is the smallest, take measurements at a position as close to the focal position as possible.
  If the measured position is off the focal position, the measurement accuracy will be reduced.



- Beam diameter at each position
  The laser scanning beam is stopped down so that it has a minimum diameter at the measurement position (focal position). Since the beam diameter gets thicker the farther it gets from the focal point, the repeatability will be reduced if measurements are taken far out.
  Therefore, always perform measurement at the focal position.
  Particularly, note that LSM-500S and LSM-501S have a narrow measuring region. If a very thin workpiece is measured outside the measuring region, "Err-0" (no objective workpiece present) may be displayed.



- Check the measurement position in the up/down direction with the W.P. LED.

5.3 Applied Measurement

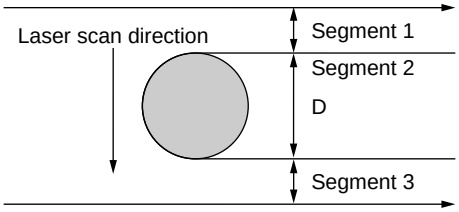
Perform measurement according to the conditions set.

This section gives example operations for a better understanding of the versatile functions of this instrument.

For information about actual setup methods refer to Section 3.4, “Outline of Key Operations”, Section 4.1, “Basic Setup”, and Section 4.5, “Setting up the Functions”.

5.3.1 OD measurement of a precision-machined workpiece

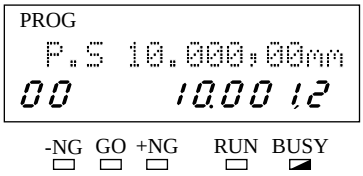
Perform a single-run measurement and make a GO/NG judgment of the workpiece OD.



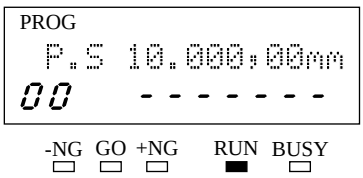
- Suppose that D = $10^{\pm 0.002}$ mm.
- Set the following:
  1. Segment = 2
  2. Number of scans for averaging = 512 or more
     For precision measurement set a large value.
  3. GO/NG criteria
     a. Lower limit value = 9.998 mm
     b. Upper limit value = 10.00201 mm
     (If 10.002 mm is accepted as GO, add the resolution to this value. This also applies to the following examples.)

- Measurement

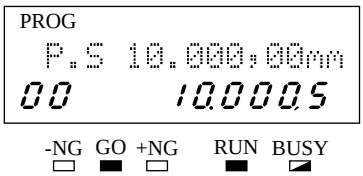
  1. Perform measurement in the ready state.
     The GO/NG LEDs and RUN LED are off, and the BUSY LED turns on for each measurement.



  2. Start a single-run measurement. “- - - - - - - -” will be displayed in the lower section of the display unit. Also, the RUN LED lights and stays lit.



  3. After the set measurement interval (approximately 0.32 seconds, for 1024 times averaging), the BUSY LED lights for a moment, then the measured data is latched on the display.
     The measured data is subjected to GO/NG judgment, and the result will be outputted on the GO/NG LEDs. It will also be, depending on the setup, outputted to the RS-232C (printer)/GP-IB and Digimatic Code Output Unit.



TIP About the number of scans for averaging and repeatability
If high accuracy is required, select the largest number of scans for averaging possible.
In general, the more increasing the number of scans for averaging, the more repeatability is improved.

5.3.2 Measurement of magnet coil wire that runs at high speed

This instrument makes 1600 scans per second, which makes it possible to make high accuracy measurements of workpieces that move at high speed and vibrate.

In the wire drawing process or coating process in which the wire OD must be precisely controlled, it is usual to feed back the OD measurement data so that the diameter of the wire can be controlled to within the tolerance limits. To avoid a significant change in the feedback, it is most common to use the moving average.

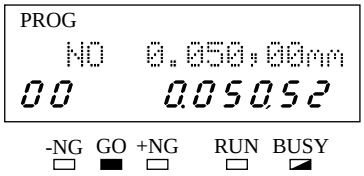
Below is an example of magnet coil wire with a diameter of ø0.05 $^{\pm 0.001}$ mm (50 ± 1 μm):

- **Basic setup**
  1. GO/NG judgment and analog output specification in the ready state
     In the ready state, specify that GO/NG judgment and analog output be performed.
  2. Averaging method
     Specify the moving average.
  3. Method of GO/NG judgment
     Specify (target value + tolerance)
     In addition, set so that the target value can be copied onto the reference value.
  4. Other settings
     Set as required for the operation environment.

- **Function setup**
  1. Segment = 2
  2. Number of scans for averaging = 512 (or, 1024 or 2048 times)
  3. GO/NG judgment
     a. Target value = 0.05 mm
        The same value will be automatically set for the reference value. If the scale number has not been set (i.e. 0), it is set to “1”. If it has been set, it is not changed.
     b. Lower tolerance limit = -0.001 mm
     c. Upper tolerance limit = 0.001 mm

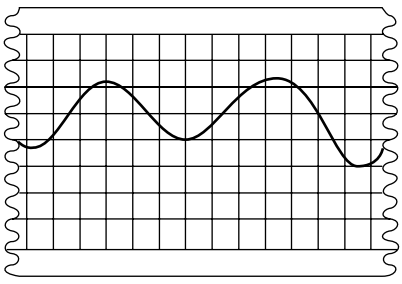
- **Measurement**

  If the power is on, measurement automatically starts after the internal error checks have been performed. The measured data will be displayed. At the same time the GO/NG judgment result will be outputted for the GO/NG LEDs and I/O interface. The difference from the target value will also be outputted as analog signals.



  Record of analog output will facilitate process analysis.

Record of analog output



TIP Through the basic setup the following functions are made available in addition to those above.

1. The display value can be held while the HOLD signal is on, by specifying “HOLD” input for OFFS signal input of the I/O interface.
2. The analog output signal voltage representing the wire breakage (Err-0) can be selected from 0V, +5V, and -5V.

5.3.3 Measurement of the lead pitch of a multiple-pin IC

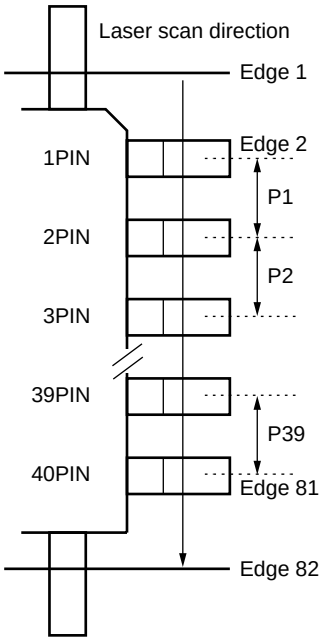
If the edge specification is made, it is possible to measure a dimension between two optional edges from between 1 and 255 edges. This can be applied to inspecting the IC lead bend and measurement of the head gap of an HDD.

Below is an example where the IC lead bend of a 160-pin flat package IC must be checked using the automatic workpiece detection function. Assume that the pin thickness and lead-to-lead interval are identical according to the specification.

The following IC specifications are used: 40 leads are on one side, the lead-to-lead interval is 0.635 mm (1/40"), the pitch tolerance is 0.01 mm.

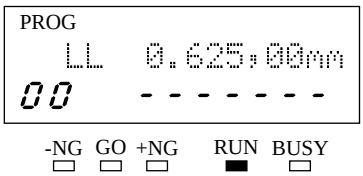
- **Basic setup**
  1. Segment specification
     Specify the edge specification method.
  2. Automatic workpiece detection
     Specify use of automatic workpiece detection.

- **Function setup**
  1. Segment
     a. Start segment = 2
     b. Finish segment = 81
        (Last lead number x 2 +1)
  2. Number of scans for averaging = 32
  3. GO/NG judgment
     a. Lower limit = 0.625 mm
     b. Upper limit = 0.645 mm
  4. Setting automatic measurement
     Specify the pitch measurement.
  5. Automatic workpiece detection setup
     Measurement time = 1
     Invalidation period = 20 ms
     Lower detection limit = 0.6 mm
     Upper detection limit = 0.67 mm

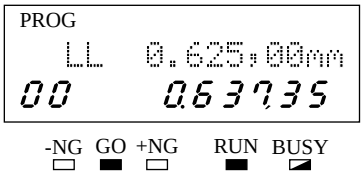


- **Measurement**

Press the C.RUN key.
" - - - - - - - - " is displayed and continuous-run measurement starts.
Provided that edges 1 through 82 are detected within the measuring region and that the measurements of the edges 2 and 3 are within the detection range, the system recognizes the workpiece presence and starts actual measurements after the elapse of invalidation period.



In approximately 0.82 second after the invalidation period the measured data will be displayed.
If the tolerancing judgment result is "GO", the mean value is displayed.
If the judgment result is "±NG", the number of the pin pitch where "±NG" was detected for the first time is also displayed.



If the next objective IC enters the measuring region, it is automatically detected and measurement will be repeated.

TIP

1. Measurement time of automatic measurement
   { (Number of objective leads of measurement) x (Measurement interval) + (calculation time: 20 ms)} = (40 x 20 + 20) ms = 0.82 second.
2. If GO/NG judgment is ±NG
   The ±NG measurement data, which is detected first, is displayed and the judgment result is outputted. Subsequent measurement is stopped.
3. For the automatic workpiece detection on IC or connector measurement, the part to be measured of the smallest edge number (falls on pin No.1) is used for detection, if the diameter-detection method is specified.
   With the position-detection method measurement starts when an edge of the smallest edge number is detected.

IMPORTANT

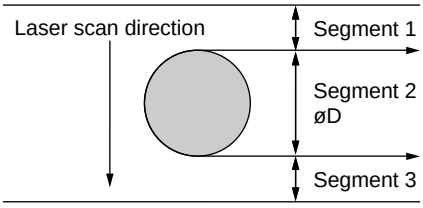
About automatic measurement of a moving workpiece
For automatic measurement on a multi-pin IC, etc., this instrument will sequentially perform measurement from the smallest edge number in the scanning range. For this reason, if any edge moves outside the scanning range during measurement, the edge number may change, resulting in incorrect measurement. Therefore, allow a sufficient measuring time including the invalidation period for automatic measurement.
If possible, take measures so that the workpiece stops within the measuring region.

5.3.4 Applied Measurement with Preset/Zero-Set Functions

1. Applied measurement with preset function 1

The preset function can be applied for converting the reference gage dimension to a nominal dimension (Figure a).

In Figure a set the preset direction to “0” (positive).



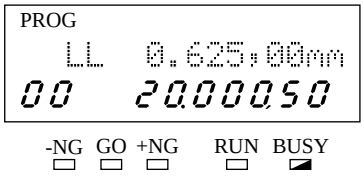
[Figure a]

Example of [figure a]

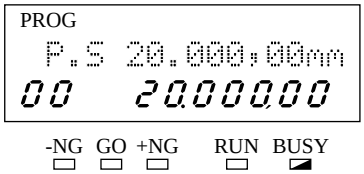
Let D = $20.0005^{\pm 0.0015}$ mm

- **Basic setup**
  Set up according to the requirement.
- **Function setup**
  1. Segment = 2
  2. Number of scans for averaging = 512
  3. GO/NG judgment
     a. Lower limit
        = 19.9985 mm
     b. Upper limit
        = 20.0015 mm
  4. Preset
     a. Set the nominal dimension of the gage to 20.0 mm.
     b. Direction = 0 (positive)
- **Measurement**

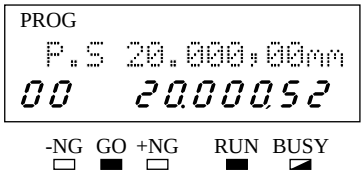
The ready state display appears as shown at the right before the preset is set.



If the preset value is set to 20.0 mm, the guidance display for the PRESET guidance indicator (▼) turns on, and the measurement is also replaced to 20.0 mm.



Press the [DATA C/RUN] key.
“ - - - - - - - - ” is displayed and single-run measurement starts.
After the first measurement interval the measurement value is displayed, and the GO/NG judgement result is outputted.



TIP
1. To re-activate the preset function using the existing preset value and direction, press the [P.S V/P.SET] key. With this single key operation, preset can be achieved.
2. It is possible to obtain a deviation from the reference gage by presetting (zero-setting) it to “0.0”.

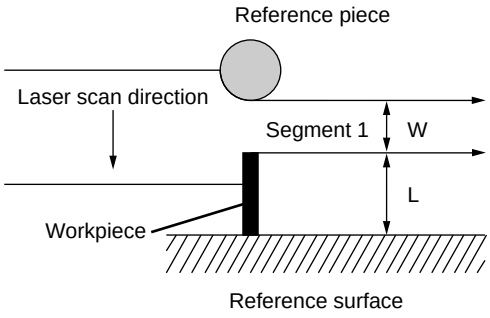
2. Applied measurement with preset function 2

The preset function is used to measure a workpiece larger than the measuring range of this system.

In Figure b set the preset direction to “1” (negative).

Example of [figure b]

Let L = 50.0 $^{\pm 0.01}$ mm



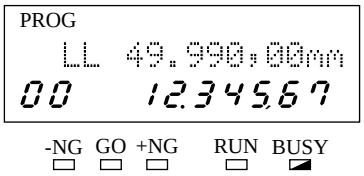
[Figure b]

- **Basic setup**
  Set up according to the requirement.

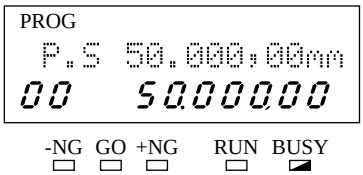
- **Function setup**
  1. Segment = 1
  2. Number of scans for averaging = 512
  3. GO/NG judgment
     a. Lower limit = 49.99 mm
     b. Upper limit = 50.01 mm
  4. Preset
     a. Set to 50.0 mm.
     b. Direction = 1 (negative)

- **Measurement**

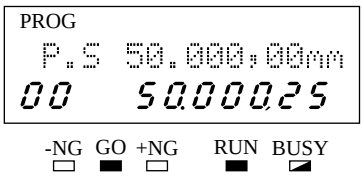
  The ready state display appears as shown at the right before the preset is set.
  Since the preset has not been set, the gap of segment 1 is measured.



  Set the preset to 50.0 mm. The measurement value is also replaced by 50.0 mm.
  As the gap measurement is selected, set here the negative direction (1).

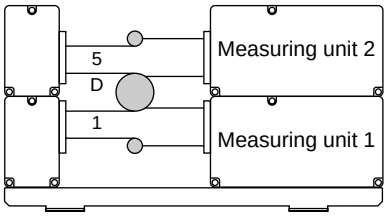


  Press the DATA C/RUN key.
  “ - - - - - - - ” is displayed and single-run measurement starts.
  After the first measurement interval the measured value is displayed, and the GO/NG judgment result is outputted.



3. Applied measurement of preset 3

Make the combined preset enabled in the DF-type dual-unit measurement.



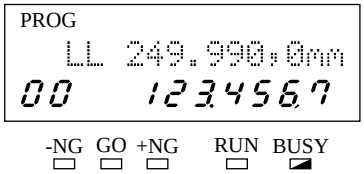
[figure c]

Example of [figure c]

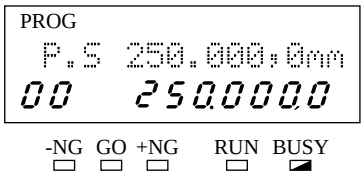
Suppose that D = $250.0^{\pm 0.05}$ mm.

- **Basic setup**
  Set the dual-unit measurement type to DF type.
- **Function setup**
  1. Segment = (1 + 5)
  2. Number of scans for averaging = 512 times
  3. GO/NG judgment
     a. Lower limit value = 249.95 mm
     b. Upper limit value = 250.05 mm
  4. Preset value
     a. Set to 250.0 mm.
     b. Direction = 1 (negative)
- **Measurement**

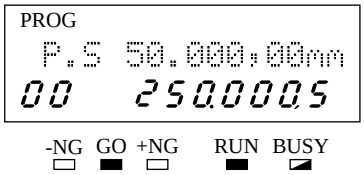
  Before setting the preset function, the display appears as shown at the right.
  Since the preset function is not enabled yet, the gap (segments 1 +5) will be measured.



  Set the preset value to 250.0 mm. Since this is a gap measurement, set the direction to 1 (negative).



  Press the DATA C/RUN key.
  " - - - - - - - - " will be displayed and single-run measurement will start.
  After the set measurement interval the measured value is latched on the display, and the GO/NG judgment result is outputted.



NOTE About the combined preset

1. The combined preset is used to measure a workpiece that has a dimension close to that of the reference gage. For measuring workpieces with various dimensions, use the combined calibration.
2. To use the combined preset together with the combined calibration, set the direction to "0" (positive).
3. If the combined calibration or individual calibration for each Measuring Unit is canceled, the combined preset is also canceled.

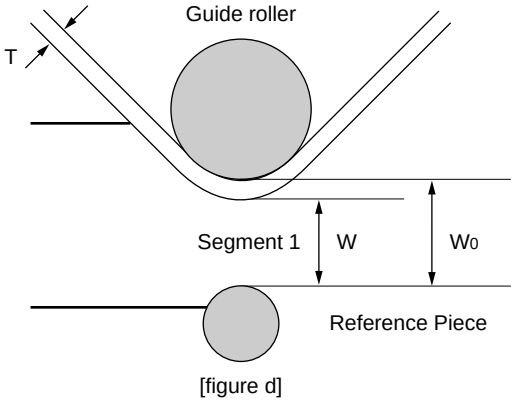
4. Applied measurement with the zero-set function

Use the zero-set function to easily measure a tape thickness.

First measure segment 1 (W_0) after removing the tape from the guide roller, which is used as a reference gage.

Set the tape as the measurement objective on the guide, then measure segment 1 (W). The tape thickness (T) is obtained from: $T = (W_0 - W)$

For this measurement use the zero-set function.



[figure d]

Convert (zero-set) W_0 to 0.0 mm and set the direction as 1 (negative). The following results: $T = \{W_0 - (-W)\} = 0.0 - (-W) = W$

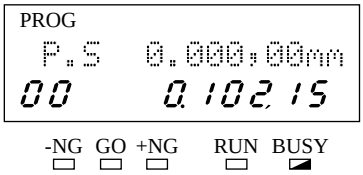
Here is an example of measuring a tape with a thickness of $T = 0.1^{\pm 0.005}$ mm.

- **Basic setup**
  Set up as required.

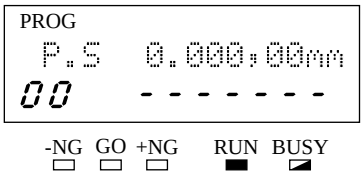
- **Function setup**
  1. Segment = 1
  2. Number of scans for averaging = 128
  3. GO/NG judgment
     a. Lower limit = 0.095 mm
     b. Upper limit = 0.105 mm

- **Measurement**

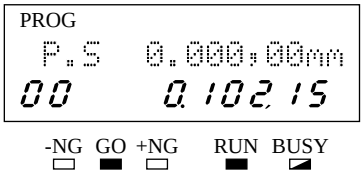
  Remove the tape and preset (zeroset) with “0.0”.
  Then set up the tape.
  The tape thickness will be displayed, however, GO/NG judgment is not performed.



  Press the [C.RUN] key.
  “ - - - - - - - ” is displayed and continuous-run measurement starts.



  At every measurement interval the measured data is displayed, and the GO/NG judgment result is outputted.
  Press the [DATA C/RUN] key or [C.RUN] key.
  The most recent measurement is displayed, and measurement is stopped.



5.3.5 Sample measurement

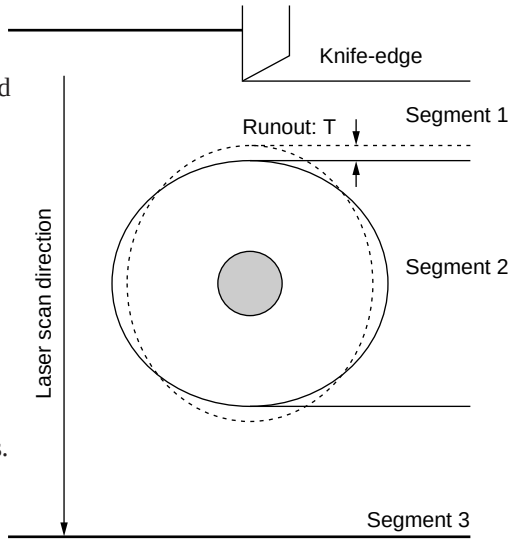
In addition to the diameter, a roller in a paper-feed mechanism requires a high machining accuracy with respect to both the roundness and cylindricity.

In this example suppose that the roller is being turned to measure the runout.

In the diagram at the right the roller is turning, and the gap of segment 1 is measured to determine the runout of T while segment 2 is measured to determine the OD.

This runout can be derived from the range (maximum - minimum) of sample measurements.

In this example a knife-edge is used for stable gap measurement, however, a round pin can also be used if appropriate.



Here is an example of measuring a rubber roller with a diameter of ø25.0 $^{\pm 0.05}$ mm and a runout tolerance of T = 0.03 mm.

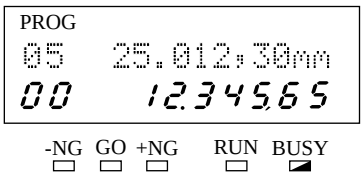
- **Basic setup**
  Specify simultaneous measurement.
- **Function setup**

Setup item	Program0 (Foreground)	Program5 (Background)
Segment	1	2
Number of scans for averaging	64	64
Lower limit value	0.0	24.95
Upper limit value	0.03	25.05
Number of sample	50	50
Statistical item	range (maximum value - minimum value)	mean

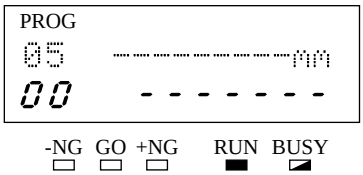
NOTE: The rubber roller must be turned more than 360 degrees. Number of scans for averaging is determined from the revolution speed and the sample number.

- **Measurement**

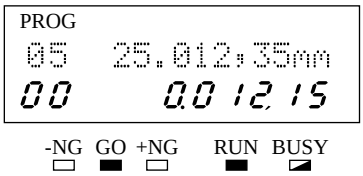
In the ready state the gap dimension of segment 1 is displayed.



Press the DATA C/RUN key to start the measurement. " - - - - - - - " is displayed and the sample measurement starts.



In this example the measurement result will be displayed and the GO/NG judgment result will be output approximately 1 second after measurement starts.



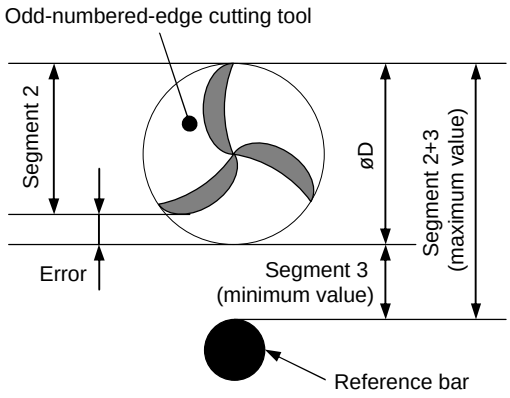
5.3.6 Application of the odd-numbered-edge cutting tool measurement

5.3.6.1 Odd-numbered-edge cutting tool outside diameter measurement

Since if the outside diameter measurement is performed on a cutting tool which has an odd number of cutting edges (such as drills and end mills) using normal Segment 2, measurement errors will be produced. Therefore, in this case, use the "Odd-numbered-edge cutting tool measurement function" for measurement.

Calculate the target outside diameter from the data collected with the "Sample measurement" while the workpiece was rotating.

This method can be applied to any outside diameter measurement of even-numbered-edge cutting tool and gear teeth, etc. beside an odd-numbered-edge cutting tool.



- Measurement example: (case of the above shown settings)

Workpiece	3-cutting-edge end mill/øD = ø10.0$^{\pm 0.003}$mm
Layout of reference bar (edge)	Segment 3 (lower) side
Number of workpiece revolutions	4 rpm

- Modifying the basic setup:

Setting item	No.	Item display	Setup contents
Odd-numbered cutting edge measurement	B3	TOOL	USE3

- Modifying the basic setup:

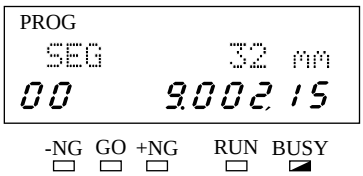
Setting item		No.	Item display	Setup contents
Segment		F0	SEG	Automatic setup (*1)
Number of averaging times		F1	MR	128 times (*2)
GO/NG judgment	Lower limit value	F2	LL	9.997 mm
	Upper limit value		LH	10.003 mm
Number of samples		F6	SMP N	0 (Zero-run measurement)
Calculation item			SMP ITM	TOOL.D (tool outside diameter)

(*1): At the stage when "TOOL.D" is set from the "Calculation item", the available segments will be automatically set and the guidance for that item will not be displayed any more.

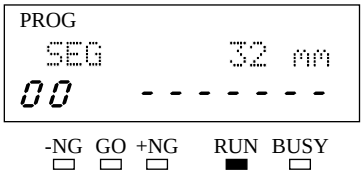
(*2): It is necessary to measure the workpiece (odd-numbered-edge cutting tool) while rotating it. Determine the number of averaging times depending on the number of workpiece revolutions.
(In this example it is assumed that the number of workpiece revolutions is approximately 4 rpm.)

• Measurement:

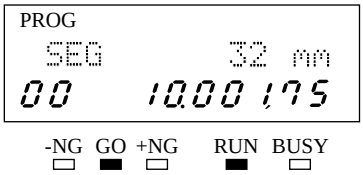
Step 1: In the stand-by state the indicated value includes errors (i.e. it is smaller than the actual dimension), since the measured value of Segment 2 is displayed. At this stage begin rotating the workpiece.



Step 2: Enter DATA C/RUN.
When " - - - - - - - " is displayed in the lower display section, the zero-run measurement commences.



Step 3: If DATA C/RUN is entered again after the workpiece has been rotated for more than one turn since the start of measurement, the measured value will be latched on the display and then the measurement is completed.



TIP Relationship between "Number of workpiece revolutions" and "Number of averaging times"

• The following table shows the relationship between "Number of workpiece revolutions" and "Number of averaging times" if 360 pieces of data are obtained while the workpiece rotates one full turn (at 1° increments). Use it as a standard.

Number of averaging times	Number of workpiece revolutions	Measuring time (Time required for one revolution)
32	16 rpm	approx 3.8 sec
64	8 rpm	approx 7.5 sec
128	4 rpm	approx 15 sec
256	2 rpm	approx 30 sec
512	1 rpm	approx 60 sec
1024	0.5 rpm	approx 120 sec

• The more the number of averaging times, the repeatability will be more stable. In order to measure at a highest accuracy, set this number of averaging times as large as possible (the number of revolutions is as small as possible).

5.3.6.2 Odd-numbered-edge cutting tool run-out measurement

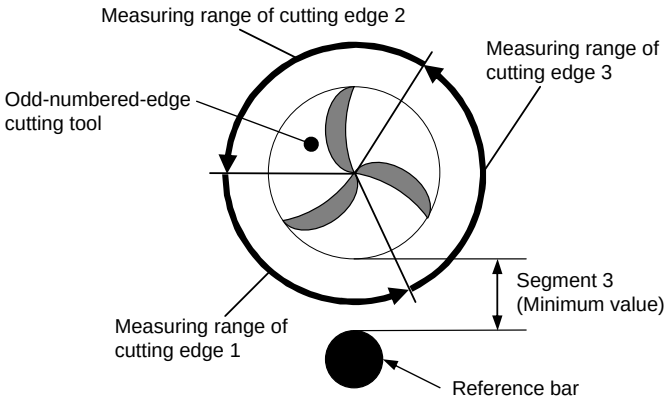
Measure the run-out of the cutting edge of the odd-numbered-edge cutting tool as follows.

As shown in the figure below, set the measuring rage so as to separately contain each cutting edge.

Measure the minimum value of Segment 3 in each edge measuring range through the "Sample measurement".

Calculate the range (maximum - minimum) of the measured data as many as the number of cutting edges being set, and display the result as the measured data of "Run-out".

This method can be applied to any run-out measurement of even-numbered-edge cutting tool and gear teeth (teeth tips), etc. beside an odd-numbered-edge cutting tool.



- Measurement example: (case of the above shown figure)

Workpiece	3-cutting-edge end mill/øD = ø10.0 mm
Layout of reference bar (edge)	Segment 3 (lower) side
Number of workpiece revolutions	4 rpm

- Modifying the basic setup:

Setting item	No.	Item display	Setup contents
Odd-numbered cutting edge measurement	B3	TOOL	USE3

- Modifying the function settings:

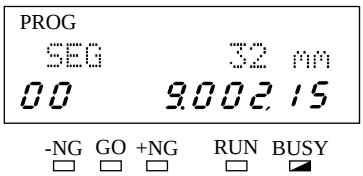
Setting item	No.	Item display	Setup contents
Segment	F0	SEG	Automatic setup (*1)
Number of averaging times	F1	MR	128 times (*2)
Number of samples	F6	SMP N	0 (Zero-run measurement)
Calculation item		SMP ITM	TOOL.R (Tool run-out)
Number of cutting edges of the tool		TOOL.N	3

(*1): At the stage when "TOOL.R" is set from the "Calculation item", the available segments will be automatically set and the guidance for that item will not be displayed any more.

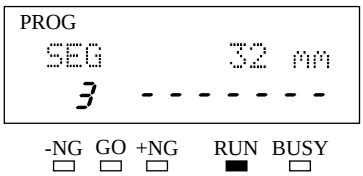
(*2): It is necessary to measure the workpiece (odd-numbered-edge cutting tool) while rotating it. Determine the number of averaging times depending on the number of workpiece revolutions.
(In this example it is assumed that the number of workpiece revolutions is approximately 4 rpm.)

• Measurement:

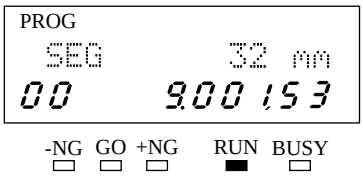
Step 1: In the stand-by state the indicated value includes errors (i.e. it is smaller than the actual dimension), since the measured value of Segment 2 is displayed. Set the start point of “Measuring range of cutting edge 1” to the measuring point.



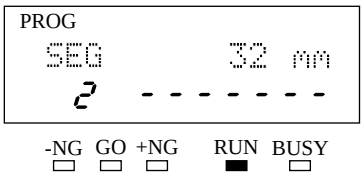
Step 2: Enter [DATA C/RUN].
When “ - - - - - - - - ” is displayed in the lower display section, the zero-run measurement commences.
The numerical data shown in the lower section of display unit at this time means “Number of cutting edges not measured yet (number of remaining measurements)”. In this example, the cutting tool will automatically stop after once it has rotated at the speed of 4 rpm (number of revolutions) to the finish point of “Measuring range of cutting edge 1”.



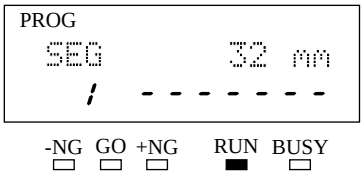
Step 3: If [DATA C/RUN] is entered again after the rotation has stopped rotated, “Temporary measurement” of Cutting edge 1 will be latched on the display and then the measurement is completed for the time being.



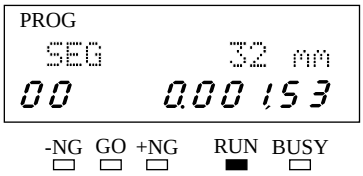
Step 4: In the same way, perform measurement for “Measuring range of cutting edge 2” according to the procedure of Step 2 and Step 3.



Step 5: In the same way, perform measurement for “Measuring range of cutting edge 3” according to the procedure of Step 2 and Step 3.



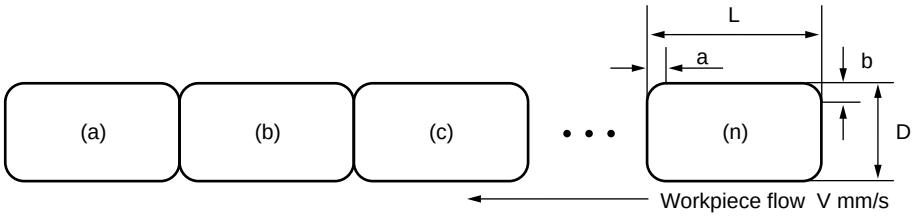
Step 6: In this example, as the number of cutting edges is set to “3”, the measured data will be calculated and the result will be latched on the display at the stage when the measurement of “Measuring range of cutting edge 3” is completed, then the measurement will be terminated.



TIP For the relationship between “Number of workpiece revolutions” and “Number of averaging times” refer to Section 5.3.6.1 “Odd-numbered-edge cutting tool outside diameter measurement”.

5.3.7 Applied measurement with automatic workpiece detection

If a workpiece of the specified range of dimension enters the measuring region, measurement will be automatically started.



D = $5.0^{\pm 0.0015}$ mm, L = 12 mm, chamfer a = 0.5 mm, b = 0.5 mm, and V = 50 mm/s.

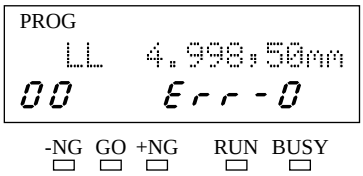
- **Basic setup**
  Select the OD detection method for automatic workpiece detection, and specify 16 for the detecting speed (number of scans).

- **Function setup**
  1. Segment = 2
  2. Number of scans for averaging = 512
     Set to the maximum value of (Measurement interval) < (L- 2a) / V.
  3. GO/NG judgment
     a. Lower limit = 4.9985 mm
     b. Upper limit = 5.0015 mm
  4. Analog output
     a. Reference value = 5.0 mm
     b. Scale value = 1
        To be set if used.
  5. Automatic workpiece detection
     a. Number of measurements n = 1
     b. Invalidation period t = 50 ms
        t > (a / V)
     c. Lower detection limit L = 4.9 mm
        Set using the dimension excluding the chamfered portion.
     d. Upper detection limit H = 5.1 mm

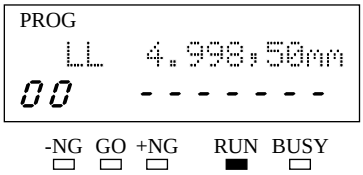
NOTE About automatic workpiece detection
If sequentially fed workpieces have a small chamfer and they are almost in contact, workpieces may not be clearly identified. If this is the case, use connection rods, for example, for adequate intervals.
In addition, allow a sufficient margin for the invalidation period and upper and lower detection limits.

- **Measurement**

The diagram at the right indicates that no workpiece is present in the measuring region in the ready state.

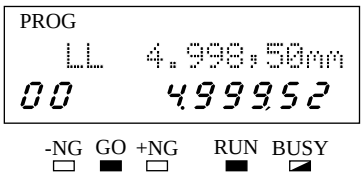


Press the C.RUN key to start continuous measurement while changing the display from "Err-0" to "--------." If workpiece (a) enters the measuring region, OD measurement will automatically be started.

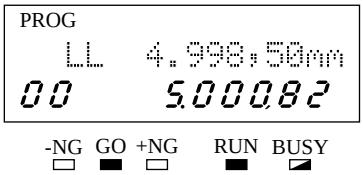


If the OD measurement resulting from 16 scans is within the preset limits, a workpiece is judged as being present ("workpiece present"). The system waits until the specified invalidation period elapses.

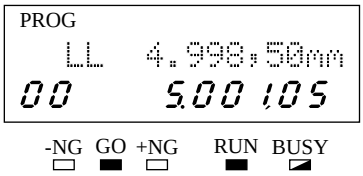
After the invalidation period elapses, OD measurement of workpiece (a) is started. At every measurement interval the measured data will be displayed and the GO/NG judgment results will be output.



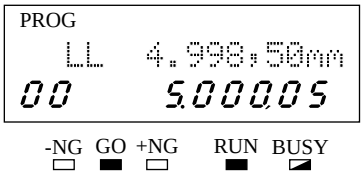
Measurement of workpiece (b) entered.
As with workpiece (a) measurement is performed and the results are displayed.



Workpieces that enter the measuring region are measured sequentially.

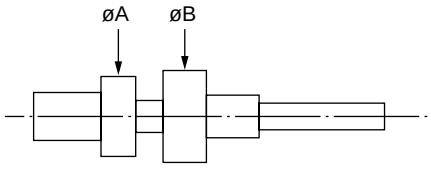


To terminate measurement, press the DATA C/RUN key or C.RUN key again.
The most recently measured data will be displayed.



5.3.8 Applied measurement on a stepped round bar

In this example 10 stepped round bars are measured and the results are statistically processed. If ±NG measurement is obtained, it will be automatically printed out.
In the figure at the right suppose the following:
øA: ø6 $^{\pm 0.01}$ mm
øB: ø10h7 $^{0}_{-0.015}$ mm



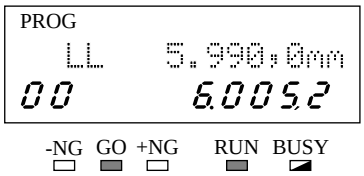
- **Basic setup**
  1. Set the resolution to 0.1 µm.
  2. Specify the RS-232C port as the printer port.

- **Function setup**

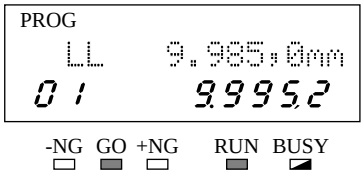
Setup item	Program0 (Foreground)	Program1 (background)
Segment	2	2
Number of scans for averaging	512	512
Lower limit value	5.99	9.985
Upper limit value	6.01	10.0
Data output condition	2	2
Other condition	0 (cancel)	0 (cancel)

- **Preparation for measurement**
  Press the [SHIFT] and [A.CL/M.CL] keys to clear all of the statistical memory, then press the [STAT/S.E] key to start statistical processing. If the statistical processing mode is entered, the S.E. guidance indicator (▼) turns on.

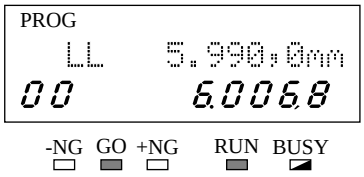
- **Measurement**
  Perform a single-run measurement for the A dimension by program No.00 after setting the workpiece in place. The measured data will be displayed and the GO/NG judgment result will be outputted.



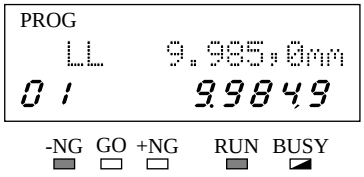
  Change to Program No.01 for the B dimension to be measured through single-run measurement.
  The measured data will be displayed and the GO/NG judgment result will be outputted.



  Change the workpiece and repeat the same measurements.

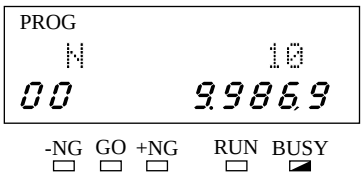


  If the result is ±NG, it will be automatically printed out.



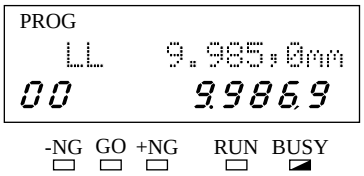
- **Confirming the statistical data on the display (not always required)**

  Press the SHIFT and STAT/S.E keys in the ready state to enter the statistical display mode for Program No.0. If this mode is entered, the number of samples is displayed first.



  Each time the ENT key is pressed, the statistical processing item changes in the following order: Number of samples: N → Standard deviation: S.D → Maximum value: MAX → Minimum value: MIN → Mean: AVG → Range: R → Number of samples: N.

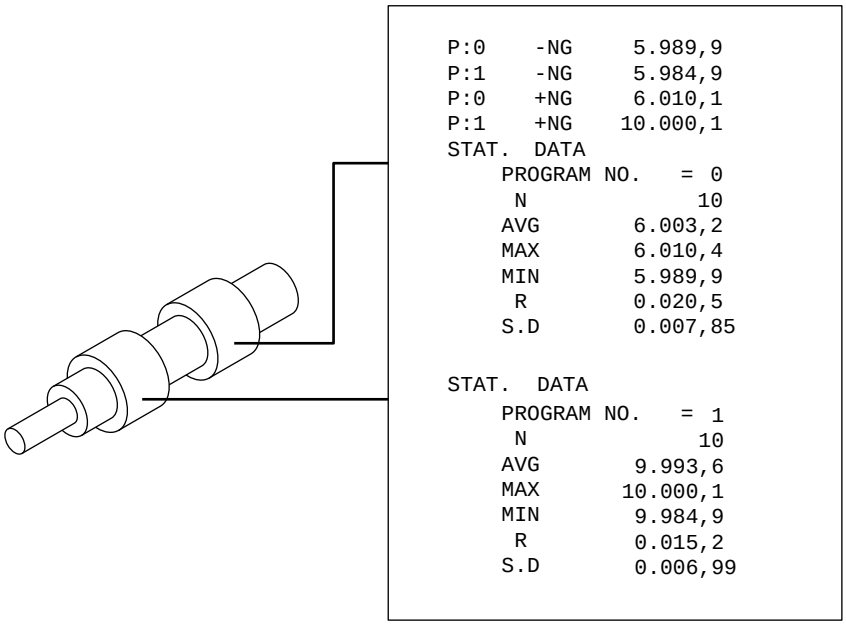
  Press the SHIFT and STAT/S.E keys to return to the ready state, and confirm the statistical data of Program No.1 in the same way.



- **Printing the statistical data**

  Use the SHIFT and S.PR/PRINT keys to print out the statistical data. This automatically clears all of the statistical memory after printout.
  An example printout is shown below.

An example printout



```
P:0    -NG     5.989,9
P:1    -NG     5.984,9
P:0    +NG     6.010,1
P:1    +NG    10.000,1
STAT.  DATA
     PROGRAM NO.   = 0
      N              10
     AVG         6.003,2
     MAX         6.010,4
     MIN         5.989,9
      R          0.020,5
     S.D         0.007,85

STAT.  DATA
     PROGRAM NO.   = 1
      N              10
     AVG         9.993,6
     MAX        10.000,1
     MIN         9.984,9
      R          0.015,2
     S.D         0.006,99
```

MEMO

6 INTERFACE UNIT

This chapter describes the setup method and functions provided with the I/O analog interface and RS-232C interface of this unit.

6.1 Standard Interface

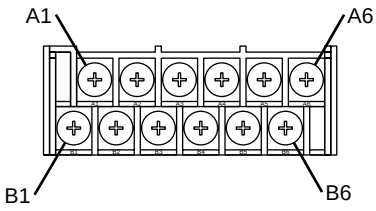
6.1.1 I/O Analog Interface

Below is a description of the I/O analog output interface.

This interface is used to communicate with a PC, programmable controller, by means of sequential signals. Since it can also capable of analog output, which may be used for feedback controls and continuous recording of workpiece deviations.

6.1.1.1 External view of the connector

Open the protection cover of the terminal block to access to the terminals. At your wiring use the supported signal-name seals that correspond to each terminal number for identification.

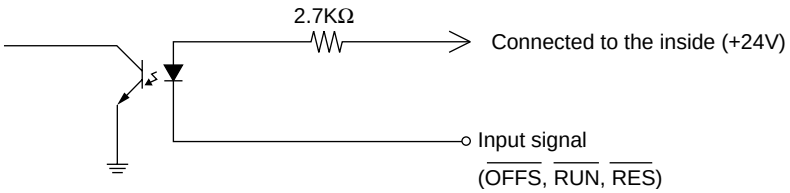


6.1.1.2 Terminal names

Terminal No.	Signal name	Function	I/O direction
A1	FG	Frame ground (connected to the casing) Used for connecting the shielded wire of I/O signal cables	—
A2	STS	Output of measurement condition (status) Turned out H level (OFF) in the event of "Err-0"	Out
A3	$\overline{GO}$	• GO/NG judgment result output ($\overline{GO}$) • With the basic setup, this can be changed to strobe signal ($\overline{STB}$) or measurement in-progress signal ($\overline{ACK}$) output.	Out
A4	$\overline{+NG}$	GO/NG judgment result output ($\overline{+NG}$)	Out
A5	$\overline{-NG}$	GO/NG judgment result output ($\overline{-NG}$)	Out
A6	GND	GND Digital ground Common ground terminal of both output (A2 thru A5) and input (B4 thru B6)	Out
B1	FG	Frame ground (connected to the casing) Used for connecting the shielded wire of I/O signal cables	—
B2	ALG	Analog voltage output	Out
B3	0V	0V output of analog voltage output	Out
B4	$\overline{PSET}$	Preset input Can be changed to hold ($\overline{HOLD}$) by the basic setup.	In
B5	$\overline{RUN}$	Input of trigger command of single-run measurement Can be changed to a trigger for continuous-run measurement with term specification by the basic setup.	In
B6	$\overline{RES}$	• Input of CLEAR command, same as the [C] key	In

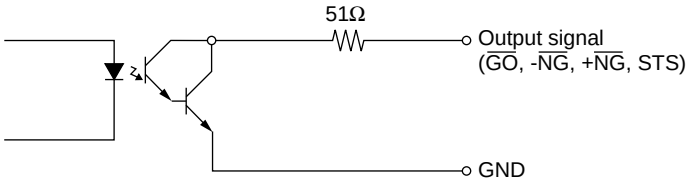
6.1.1.3 Input/output equivalent circuit

(1) Input circuit



- Input low-level signals between 0 and 1 V. Generally drive this circuit with an open collector-type transistor.
- Maximum current drawn from the input signal terminal is 12 mA.

(2) Output circuit



- Maximum rating of the output transistor is 30 V, 50 mA.

(3) Analog output

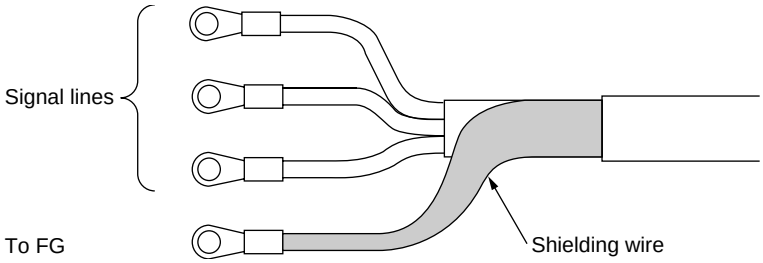
Refer to Section 6.2.2.4 , “Analog output”.

TIP

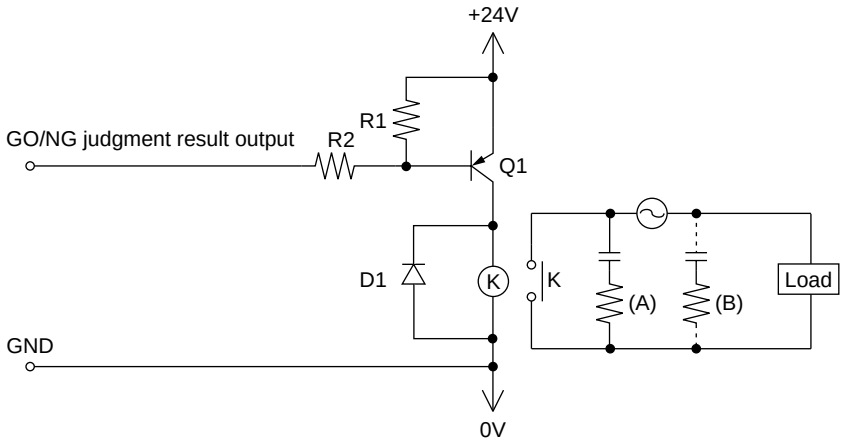
1. If “Err-0” (specified workpiece not present) occurs, the following remedies are taken:
   - ±NG and GO signals are turned OFF if this error occurs.
   - Single-run measurement and zero-run measurement will be terminated without outputting the results.
   - During continuous-run measurement or continuous-run measurement with term specification ACK remains ON. The measurement can be resumed after “Err-0” is rectified.
2. Connecting the second I/O interface will disable the input circuit/output circuit of the standard interface.
   (Analog output can be used.)

TIP

- Terminal “GND” and “0V” are connected to “FG” (Frame of LSM-6200). Therefore, keep the voltage level of these terminals to 0V.
- In practice, do not make connections to the “GND” terminal for the control input and “0V” terminal for analog output. Otherwise, this system may result in an operation error due to electrical interference or other problems.
- Always use a shielded-wire cable. Otherwise, the system may experience electrical interference resulting in operation errors. Or, radio frequency will be emitted from this system and interfere the electrical equipment.
  Use the following diagram for fabricating the cable.



- Observe the following precautions when relays are used for control circuits. Use the following diagram when designing the control circuit.
  1. Several kV of current may be induced the moment the relay is turned OFF, which may cause relay-driven components to be damaged. Or, the induced voltage may cause the system to malfunction. Always insert protective components such as diodes in the circuit.
  2. To drive equipment that operates on alternative current, always implement a protective circuit (spark killer) to protect the relay contacts. In general, if the current load is caused by induction, add protective circuit (A) or (B).
  3. Refer to the manual of each relay for selection. It describes the method of calculating the protection circuit (or selection of protective parts) depending on the load.

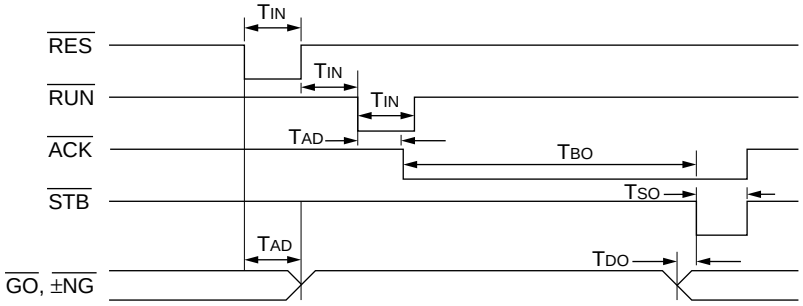


Recommended values:
Suppose that the sensitivity of a relay is 50 mA, the following design is recommended:

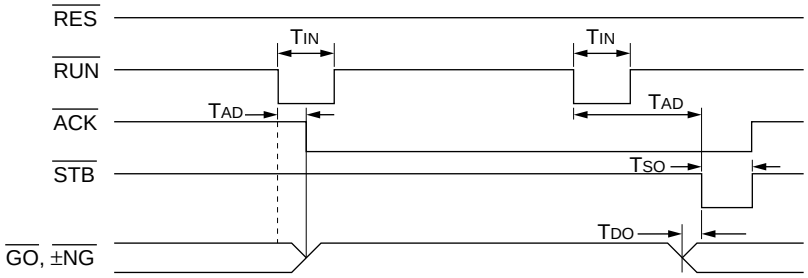
- R1: 4.7 kΩ, R2: 4.7 kΩ
- Q1: 2SA953 (Manufacturer: NEC, etc.)
- D1: 10D10 (Manufacturer: Japan Inter, etc.)

6.1.1.4 Timing chart

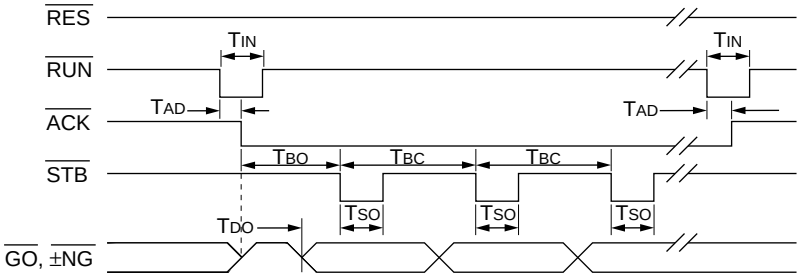
- Single-run measurement



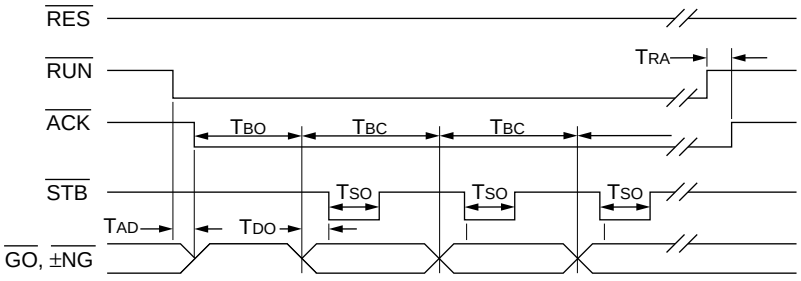
- Zero-run measurement



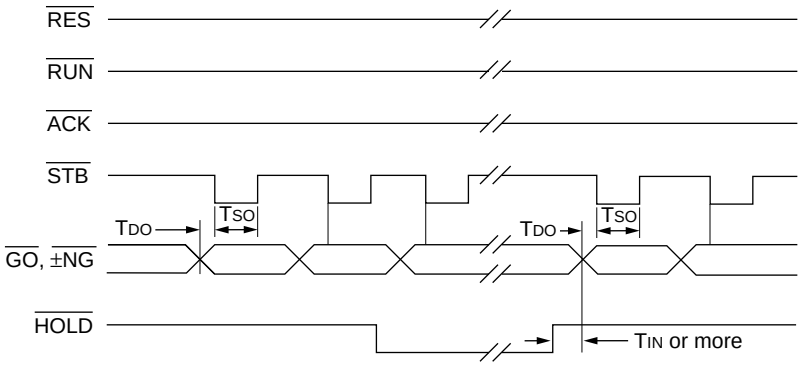
- Continuous-run measurement



- Continuous-run measurement with term specification



- Output in the ready state (if the basic setup is determined to enable output in the ready state)



- Response time

Item	Response time	Description
TIN	> (Tif x 2 + 3 ms)	Input time
TAD	< (Tif x 2 + 3 ms)	Acceptance time
Tif	5 ms, 2 ms, 20 ms Can be selected by Expanded basic setup (“7 IFF”).	Delay time by filter
TSO	Refer to p.6-37, p.6-38, Strobe length (TSO).	Strobe length
TDO	0.05 ms to 0.2 ms	Data setup time
TBO	< (Tmr x N + 3 ms)	Duration of Single-run measurement
TBC	< (Tmr x N + 1 ms)	Duration of continuous-run measurement
TBD	< (Tmr + 1 ms)	Duration of ready state
Tmr	Refer to p.6-37, p.6-38, Measurement interval (Tmr)	Measurement interval
N	Refer to Section 9.2.4, Number of samples (“6 SMP N”). And refer to Section 4.5.3.8, Number of samples (“6 SMP N”)	Number of samples (SMP N)

- Other
  1. Use negative-true logic pulses of TIN or more for the input signals.
  2. $\overline{\text{RES}}$ signal clears the previous measurement result and interrupts the measuring operation.
  3. Simultaneous input of multiple signals is not accepted.
  4. During measurement only $\overline{\text{RES}}$, $\overline{\text{RUN}}$ or $\overline{\text{HOLD}}$ signals are accepted.

NOTE
1. Zero-run measurement is enabled only if the $\overline{\text{RUN}}$ input is set to “S.RUN” in the basic setup.
2. While the $\overline{\text{HOLD}}$ signal is ON, the $\overline{\text{GO}}$, $\overline{\pm\text{NG}}$, $\overline{\text{STB}}$ and analog output signals are held without being updated.

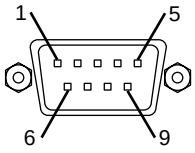
6.1.2 RS-232C Interface

The standard RS-232C interface of this Display Unit allows the LSM to communicate with external devices via RS-232C (EIA standard) serial signals.

Prior to using this interface , set up the baud rate, data bits, and parity check, etc. according to Section 4.1, “Basic Setup”. The setting contents must be compatible to that on the external device to be connected.

6.1.2.1 Specifications

- Applicable plug connector: D-sub 9 pin (Female) (Manufacturer: AMP, HD-20/747951-1)or equivalent.



The pin numbering for this system is shown at the left

- Communication specifications

Device definition	Specify the LSM as a terminal (DTE)	
Communication method	Full-duplex	
Synchronizing method	Start/stop method (asynchronous)	
Baud rate	4800, 9600, 19200, 38400 bps	
Data configuration	Transmission code	ASCII
	Data bits	7 or 8 bits
	Start bit	1 bit
	Stop bit	1 bit
	Parity check	None, odd, or even
	Delimiter	CR+LF, CR, LF

NOTE
1. The shaded settings are the factory defaults.
2. In the above table “none parity” can not be selected if the data bits are 7 bits in length. In this case, set the parity to either odd or even, or set the data bits to 8 bits.

TIP
1. DTR and RTS signals from the LSM will be ON immediately after power on.
2. DSR signals to the LSM are always ignored.

6.1.2.2 Connections

(1) Connecting the RS-232C interface to a device specified as a terminal (DTE)

Example 1 Flow control method (handshake method controlled by CTS, DSR, DTR, and RTS signals)

Personal computer (PC-AT compatible) specified as a terminal (DTE)

Signal name	Pin No.
DCD	1
RxD	2
TxD	3
DTR	4
SG	5
DSR	6
RTS	7
CTS	8
RI	9

9-pin D-sub

LSM: specified as a terminal (DTE)

Pin No.	Signal name
1	
2	RxD
3	TxD
4	DTR
5	SG
6	DSR
7	RTS
8	CTS
9	

9-pin D-sub

Example 2 Flow control method (handshake method controlled by CTS, DSR, DTR, and RTS signals)

Personal computer (PC-9801) specified as a terminal (DTE)

Signal name	Pin No.
FG	1
TxD	2
RxD	3
RTS	4
CTS	5
DSR	6
SG	7
DCD	8
DTR	20

25-pin D-sub

LSM: specified as a terminal (DTE)

Pin No.	Signal name
1	
2	RxD
3	TxD
4	DTR
5	SG
6	DSR
7	RTS
8	CTS
9	

9-pin D-sub

Example 3 3-Wire method (teletype protocol using TxD, RxD and SG)

Personal computer (PC-AT compatible) specified as a terminal (DTE)

Signal name	Pin No.
DCD	1
RxD	2
TxD	3
DTR	4
SG	5
DSR	6
RTS	7
CTS	8
RI	9

9-pin D-sub

LSM: specified as a terminal (DTE)

Pin No.	Signal name
1	
2	RxD
3	TxD
4	DTR
5	SG
6	DSR
7	RTS
8	CTS
9	

9-pin D-sub

(2) Connecting the RS-232C interface to a device specified as a modem (DCE)

Example 1 Flow control method (handshake method controlled by CTS, DSR, DTR, and RTS signals)

Device specified as a modem (DCE) — LSM: specified as a terminal (DTE)

Signal name	Pin No.		Pin No.	Signal name
DCD	1		1	
RxD	2	→	2	RxD
TxD	3	←	3	TxD
DTR	4	←	4	DTR
SG	5	—	5	SG
DSR	6	→	6	DSR
RTS	7	←	7	RTS
CTS	8	→	8	CTS
RI	9		9	
9-pin D-sub			9-pin D-sub	

Example 2) DPU-414: Printer (controlled by RTS signal)

The DPU-414 series printer (Manufacturer: Seiko Electronics Co., Ltd.) should be connected as follows:

DPU-414 series printer — LSM: Defined as terminal (DTE)

Signal name	Pin No.		Pin No.	Signal name
	1	·····	1	
TxD	2	→	2	RxD
RxD	3	←	3	TxD
*1	4	·····	4	DTR
SG	5	—	5	SG
*1	6	·····	6	DSR
	7	·····	7	RTS
RTS	8	→	8	CTS
	9	·····	9	
9-pin D-sub			9-pin D-sub	

*1: Pin Nos. 4 and 6 of the printer-side connector are internally connected.
*2: Possible to use a straight-type cable (In this case, it is not necesary to install wirings shown by the dotted lines) .

NOTE

1. The signals names and pin assignment described here may be different from that of the user's devices. Refer to the user's manual of your own device when making connections.
2. For this connection always use cables that have a shielding net. Both ends of this shielding net should be connected (grounded) to the RS-232C connector case. If the system malfunctions due to external interference noises or high frequency noise emitted by the system causes interference on radios, TVs, or other, use shielded wires with mesh.

6.1.2.3 Printer interface

- Depending on the basic setup the RS-232C port can be used as a printer port.
- The applicable printer is a DPU-414 series manufactured by Seiko Electronics, Co., Ltd. Refer to the printer manual and establish the communication settings compatible to this instrument.
  Since this instrument is subjected to the following restrictions, select the optimal conditions on the printer side.

  1. Communication speed (baud rate)
     Set to 9600 bps. Select as much as possible 9600 bps, which is the factory setting, even though the supported speeds are from 1200 to 19200 bps.
  2. Line control
     On this instrument XON/XOFF control can not be used. Select the H/W BUSY control on the printer.
  3. Print mode
     On this instrument the output is made in a format of 40 columns/line. Always select the normal print mode (40 columns/line) on the printer.
  4. Setup command
     This can not be used on this instrument.
  5. International alphabet code
     This instrument always outputs ASCII codes.

- The GP-IB interface can also be used at the same time.

6.1.2.4 RS-232C/GP-IB commands

- On this instrument either one of the RS-232C or GP-IB interfaces can be used. This selection must be made in the basic setup.
- For the descriptions about the GP-IB interface refer to Section 6.2.4 "GP-IB Interface". The SRQ status bytes of GP-IB are that follow:

	bit7	bit6	bit5	bit4	bit3	bit2	bit1	bit0
In the event of OK	0	RSV	0	0	0	0	0	0
In the event of ERx	0	RSV	0	0	1	Error No.		
In the event of data response	0	RSV	0	1	0	NG	GO	1

RSV: Set to “1” according to a service request.
NG: Set to “1” according to a ±NG measurement
GO: Set to “1” according to a GO measurement

- This section describes the reception commands used by the RS-232C and GP-IB interfaces and the response (transmission) commands that correspond to the reception commands. The data section of each command consists of ASCII codes.
- The GP-IB commands includes additional “SRQ”, “NSRQ”, and “PR” commands.
- Use the following command subscriptions, symbols and supplement descriptions when you read Section 6.1.2.5 “List of commands”.

• Command symbols

Symbol		Meaning	Entry of numeral
sssssss aaa-bbb		Segment number Start edge and finish edge of the edge specification aaa: Start edge, bbb: Finish edge	Combination using numbers between 1 and 7 Select a number between 1 and 255 However, aaa should not be identical to bbb.
±ddd.dddd		Setup data or measured data	Maximum of 7 significant digits
pp		Program Number	Select a number between 0 and 9
c		Analog output scale number	Select a number between 1 and 3
r		Data output condition	Select a number between 0 and 9
	ttt	Periodical output timer value (sec)	Select a number between 0 and 999
	tttt	Invalidation period of automatic workpiece detection (msec)	Select a number between 0 and 9999
nnn		Number of measurement times of sample measurement	Select a number between 0 and 999
	mmm	Number of measurement times of automatic workpiece detection	Select a number between 1 and 999
	nnnn	Number of scans for averaging	2^n(select between n=0 and 11)
nn		Group size subject to judgment	Select a number between 0, 1, 2 and 99
pp		SHL (Threshold level) specification (%)	Select between 5% and 95%
Δ		Space character	—

TIP

1. To ensure compatibility with the LSM-6100 Display Unit, this system ignores the following commands without treating them as ER6, but uses “OK”.
   - Memory switch command (UP0 uvxyz, UP1 uvxyz, UP2 uvxyz)
   - The MNL command is assumed to be identical to the MNH command.
2. If the setup data is “0”, it allows the corresponding function to be disabled. To set “0” as a numerical value, use “0.0”.
   Example 1 “SET, PS0” ..... Preset function is disabled.
   Example 2 “SET, PS0.0” ..... Preset function is enabled.
3. Setup data or measured data is denoted by ±ddd.dddd.
   - The first (most significant) digit is a sign. For commands that do not specifically designate the polarity, such as the calibration command, only a positive sign is accepted. However, these positive signs do not have to be specified.
   - Any decimal place is selectable.
     An integer can be entered without using a decimal point.
4. “Ppp” command can be appended to the following commands to be treated as a single command: “SET”, “R”, “CR”, “STAT”, “RP”.
   Example: P00, R
   P06, STAT
   In order to change “Ppp” (5.Program Number) with “Pp”, which is compatible with old model, change the setting of Expanded basic setup from “7PRGM” to “10”.

6.1.2.5 List of commands

Item		Reception command	Response command	GP-IB SRQ status byte
LCM clear		CL	OK	0RSV000000
Metric (mm) unit system E (inch) unit system		MM E	OK	0RSV000000
Program number change		Pp	OK	0RSV000000
Calibration	HIGH CAL set LOW CAL set	HC+ddd.dddd LC+ddd.dddd	OK	0RSV000000
Segment	Segment specification Edge specification	SG sssssss SG aaa-bbb	OK	0RSV000000
Setting the measurement interval number	Number of scans for averaging at arithmetical average	MN nnnn	OK	0RSV000000
Measurement interval number at arithmetical average	Number of scans for averaging at moving average	MNH nnnn	OK	0RSV000000
Storage of measuring conditions		STR	OK	0RSV000000
Key lock		LOCK	OK	0RSV000000
Releasing key lock		UNLOCK	OK	0RSV000000
Setting the SHL for transparent object measurement *1		SHL pp	OK	0RSV000000
Request of measuring conditions list		RP	(RP FORMAT)	0RSV000001
Setting the measuring conditions		SET	OK	0RSV000000
(Segment specification Edge specification) *2		,SG sssssss ,SG aaa-bbb		
(Number of scans for averaging at arithmetical average Number of scans for averaging at moving average)		,MN nnnn ,MNH nnnn		
(Lower abnormal limit Upper abnormal limit Count value) *2		,EL–ddd.dddd ,EH–ddd.dddd ,CNT aaa		
(Lower limit Upper limit Multi-stage selection value Target value Lower tolerance limit Upper tolerance limit) *2		,LL–ddd.dddd ,LH–ddd.dddd ,L1–ddd.dddd, Æ Æ Æ Æ, ,L6–ddd.dddd ,N–ddd.dddd ,LO–ddd.dddd ,UP–ddd.dddd		
Reference value *3		,REF–ddd.dddd		
Scale value		,SCL c		
(Positive preset Negative preset)		,PS–ddd.dddd ,PSM–ddd.dddd		

Item		Reception command	Response command	GP-IB SRQ status byte
Data output conditions		,PR r	OK	0RSV000000
Periodic data output conditions Periodic output timer		,PRT ttt		
Number of sample measurements		,SMP nnn		
Setting the statistical item for sample measurement (Maximum value, minimum value, range, mean)		,(MAX,MIN,RNG,AVG)		
Group sizes subject to judgment *2		,GN nn		
Lower tolerance limit for group judgment		,GLL±ddd.dddd		
Upper tolerance limit for group judgment		,GLH±ddd.dddd		
Statistical item for group judgment (Maximum value, minimum value, mean, range)		,(GMX,GMN,GAG,GRG)		
Start of single-run measurement		R	(DATA FORMAT)	0RSV010NGGO1
Continuous-run measurement	Measurement start command	CR	(DATA FORMAT) *4	0RSV010NGGO1
	Measurement stop command	CL	OK	0RSV000000
Zero-run measurement	Measurement start command	R	No response command	
	Measurement stop command	STOP	(DATA FORMAT)	0RSV010NGGO1
Request of measurement data		D	(DATA FORMAT)	0RSV010001
Statistical processing calculation	Performs statistical processing	ST	OK	0RSV000000
	Does not perform statistical processing	NST	OK	
Erasing the statistical processing memory	Current program only	MC	OK	0RSV000000
	All programs	MCAL		
Request of statistical processing results		STAT	(STAT FORMAT)	0RSV000001
Condition setting of automatic workpiece detection *2 • Number of measurement times • Invalidation period • Lower detection limit • Upper detection limit		AUT ,N mmm ,D tttt ,L±ddd.dddd ,H±ddd.dddd	OK	0RSV000000
Automatic workpiece detection control *2		AUT, S	OK	0RSV000000
Request of conditions list for automatic workpiece detection *2		RA	(RA FORMAT)	0RSV000001
GP-IB *5				
• Output to printer.		PR	OK	0RSV000000
• Perform service request.		SRQ	–	0RSV000000
• Do not perform service request.		NSRQ	OK	–
I/O timing signal		–	ER7	0RSV001111

*1: • If "Performing the ultra-fine wire measurement" is specified in the basic setup (also on the LSM-500H), designating this command results in ER-6.
• Do not use the SHL command unnecessarily unless there is a need, since it adversely affects the measuring accuracy.
• In order to restore the standard threshold voltage, enter the following command:
"SHL50" Resets to 50%, which is the standard.
"STR" Records the value in memory.
*2: Designating any command of the functions which are set to "Not used" in the basic setup will result in ER6.
*3: If "Copying the target value to the reference value" is specified in the basic setup, designating this command results in ER6.
*4: Responds with measurements according to the data output conditions.
*5: Results in ER6 on the RS-232C.

6.1.2.6 List of response commands if an error occurs

Response command	GP-IB SRQ status byte	Description
ER0	0RSV001000	A workpiece is not present in the specified segment. • A workpiece is not set properly. • Shutter is closed.
ER2	0RSV001010	A numeric value greatly different from the reference gage dimension is set.
ER5	0RSV001101	• Limit values for go/no-go judgment and abnormal data exclusion have been set in reverse order or equal. • Input value is too large.
ER6	0RSV001110	An unavailable command is received. • Command format is incorrect. • Baud rate and/or data bits are not consistent.
ER7	0RSV001111	Message from the external device • Measurement is interrupted by signal input from key operation or I/O interface.
ER9		Any error of communication • The communication setting of the opponent instrument is different from LSM. • Check the setup contents in the basic setup. • Isolate the cables from noise sources.

Remark: “ER6” or “ER9” may occur in the first communication right after the start up. If this happens, repeat the command transmission of “CL” until the reception of “OK” is confirmed.

6.1.2.7 Format of response commands

1) (DATA FORMAT): Data format

Ppp, (GO/NG judgment result) ±ddd.dddd (, deviation)

a. Where the GO/NG judgment is active, GO/NG judgment result (-NG, OK$_{\Delta}$ or +NG) will be appended.
b. Where the reference value is set, a deviation (, DEV±ddd.dddd) is appended. This deviation value is derived from (Measured data - Reference value).
c. In the simultaneous measurement the foreground measurement is followed by the background measurement after a comma (,) is inserted between them.

2) (RP FORMAT): Report format
PROGRAM, Ppp, SG$_{\Delta}$ sssssss, MNnnnn, LL$_{\Delta}$ ±ddd.dddd, LH$_{\Delta}$ ±ddd.dddd, REF ±ddd.dddd, SCLc, PS$_{\Delta}$ ±ddd.dddd, PR$_{\Delta}$ r, PRTttt, SMPnnn, AVG, ST$_{\Delta}$

- It varies depending on the setup.
  a. Any characters are to be added if (target value + tolerance) is specified.
  b. Any characters are to be added if the multi-limit selection is specified.
  c. Any characters are to be added if the abnormal value eliminating function is specified. Between MM and LL$_{\Delta}$ "EL$_{\Delta}$ ±ddd.dddd, EH$_{\Delta}$ ±ddd.dddd, CNTaaa" is inserted.
  d. On the GP-IB, SRQ (or NSRQ), LOCAL (or REMOT) is added after ST$_{\Delta}$ depending on the operation mode.

- Available symbols may change depending on the setup contents.
  a. SG$_{\Delta}$ sssssss → SG$_{\Delta}$ aaa-bbb
  b. MNnnnn → MNHnnnn
  c. LL$_{\Delta}$ ~ LH$_{\Delta}$ ±ddd.dddd → $_{\Delta}$ N$_{\Delta}$ ±ddd.dddd, LO$_{\Delta}$ ±ddd.dddd, UP$_{\Delta}$ ±ddd.dddd
     → L1$_{\Delta}$ ±ddd.dddd, ... , L6$_{\Delta}$ ±ddd.dddd
  e. PS$_{\Delta}$ ±ddd.dddd → PSM$_{\Delta}$ ±ddd.dddd
  f. AVG → MAX, MIN or RNG
  g. ST$_{\Delta}$ → NST

3) (STAT FORMAT): Statistical data format
STAT$_{\Delta}$ DATA, Ppp, Nnnnnnn, AVG±ddd.dddd, MAX±ddd.dddd, MIN±ddd.dddd, RNGddd.dddd,S.Dddd.dddd

- "nnnnnn" implies the number of statistical data pieces, which is maximum 100,000. Data pieces that exceed this limit will be excluded from the statistical data.

4) (RA FORMAT) : Data format for automatic workpiece detection AUT, Nmmm, Dtttt, L±ddd.dddd, H±ddd.dddd

TIP
1. The integer section of "±ddd.dddd" will be zero-suppressed.
2. The "±" section will be "-" if the value is negative, and will be removed (the following digits are left-flushed) if the value is positive.

6.1.2.8 Other commands

1) Each of the D, R, and CR commands can be appended with an “N”.
If appended with an “N”, each program number will be removed from these commands.

Item	Reception command
Data request	DN
Single-run measurement (zero-run measurement)	RN
Continuous-run measurement	CRN

Example: “D” → “P00, 12.3456” : Appended with a program number
“DN” → “12.3456” : Program number is removed.

2) Each of the D, R, CR, RP, STAT, and RA commands can be appended with an “*”.
If appended with an “*”, these commands have a fixed data length that is not zero-suppressed.

Item	Reception command
Data request	*D *DN
Single-run measurement (zero-run measurement)	*R *RN
Continuous-run measurement	*CR *CRN
Request of measuring conditions list	*RP
Request of statistical processing results	*STAT
Request of automatic workpiece detection conditions list	*RA

Example: “D” → “P00, 12.3456” : Zero suppressed.
“*D” → “P00, +012.3456” : Outputted in 7 digits without zero suppressing.

6.1.2.9 Details of command descriptions

(1) CL

(a) Format: CL
(b) Description: Functions same as the [C] key on the Display Unit.
This releases the error state, performs single-run measurement, zero-run measurement, continuous-run measurement, and releases the measurement result display latch.
(c) Example: Reception command CL
Transmission command OK

(2) MM, E

(a) Format: MM
E
(b) Description: MM: Sets the display unit to mm.
E: Sets the display unit to E (inch).
(c) Example: Reception command MM or E
Transmission command OK

(3) P

(a) Format: Ppp (pp: program number)
(b) Description: Program number is changed to the specified one.
(c) Example: Reception command P05
Transmission command OK

(4) HC, LC

(a) Format: HC+ddd.dddd
LC+ddd.dddd
(b) Description: Calibrates the LSM.
If the supplied gage is set in position and this command is executed, the proportion of the actually measured gage dimension to the entered value is calculated and the resultant constant is stored in memory, then the “OK” response will be issued. It requires several seconds.
(c) Example: Reception command HC24.0005 Transmission command OK
Reception command LC 0.9995 Transmission command OK
(d) Supplement: Negative setup data results in ER2

(5) SG sssssss, SG aaa-bbb

(a) Format: SG sssssss (sssssss: SEG No. Number of digits should be between 1 and 7. Duplicated number must not be specified.)
SG aaa-bbb (aaa: start edge, bbb: finish edge. The range is between 1 and 255 for both edges. However, aaa should not be identical to bbb.)

(b) Description: Setting the segment (measuring position).
Two types of setting are available; segment specification and edge specification.

(c) Example: Reception command SG2 Response command OK
Reception command SG2-65 Response command OK

(d) Supplement:
- Segments and edges should be set in the basic setup.
- sssssss can be set with 7 digits or less.
  Ex.) SG 1234567, SG 24, SG3, etc.
- aaa and bbb should be set within 3 digits.
  Ex.) SG1-2, SG 2-33, SG 111-255, etc.
  The order of the start edge and finish edge can be reversed.

(6) MN

(a) Format: MN nnnn (nnnn: Number of scans, between 1 and 2048)

(b) Description: Set the averaging method to the arithmetical average, and specify the number of scans to nnnn (2^n, where n= 0 to 11).

(c) Example: Reception command MN 1024
Response command OK

NOTE The number of scans must be between 16 and 2048 if the ultra-fine wire measurement is specified in the basic setup.

(7) MNH

(a) Format: MNH nnnn(nnnn: Number of scans, between 32 and 2048)

(b) Description: Set the averaging method to the moving average, and specify the number of scans with nnnn. nnnn is 2^n, where n= 5 to 11.

(c) Example: Reception command MNH 1024
Response command OK

(d) Supplement: MNL command is as same as MNH command

(8) STR

(a) Format: STR

(b) Description: Data that has been set by the RS-232C command will be erased from memory if the power is off. To retain the data after the power off, use this command to save the critical measuring conditions in memory. But the “ST” and “NST” command will not be saved.

(c) Example: Reception command STR
Response command OK

(9) LOCK

(a) Format: LOCK

(b) Description: Locks the keyboard of this machine to prevent accidental operation.
To release this key lock state, use the UNLOCK command.

(c) Example: Reception command LOCK
Response command OK

(d) Supplement: Lock set by this command can not be released with key operation.

(10) UNLOCK

(a) Format: UNLOCK
(b) Description: Releases the key lock state and enables key operations again.
(c) Example: Reception command UNLOCK
Response command OK

(11) SHL

(a) Format: SHL pp (pp: threshold level, 5 to 95%)
(b) Description: If "Performing the ultra-fine wire measurement" is specified in the basic setup, designating this command results in ER6.
Used to measure such as the width of a tape, which has a good transparency.
(c) Example: Reception command SHL 50
Response command OK
(d) Supplement: Refer to Section 3.2.4.1, "Transparent object (Workpiece that transmits light)".

(12) RP (RP FORMAT)

(a) Format: RP
(b) Description: This is used to confirm the setup contents, if the measuring conditions and operating conditions set are received as the response.
(c) Example: Reception command RP command
Response command PROGRAM, SG$_{\Delta}$ 2, M3, LL$_{\Delta}$ D 5.988, LH$_{\Delta}$ 6.010, REF6.000, SCL1, OF$_{\Delta}$ 0, PR$_{\Delta}$ 3, PRT0, SMP20, MAX, ST$_{\Delta}$

(13) SET

(a) Format: SET

Segment specification *1	, SG sssssss
Edge specification *1	, SG aaa-bbb
Number of scans for arithmetical average	, MN nnnn
Measurement interval number at moving average	, MS m
Number of scans for moving average	, MNH nnnn
Lower abnormal limit *2	, EL±ddd.dddd
Upper abnormal limit *2	, EH±ddd.dddd
Abnormal count value *2	, CNT aaa
Lower limit *1	, LL±ddd.dddd
Upper limit *1	, LH±ddd.dddd
Multi-limit selection value *1	, L1±ddd.dddd , L2 • • • • , L6±ddd.dddd
Target value *1	, N±ddd.dddd
Lower tolerance limit *1	, LO±ddd.dddd
Upper tolerance limit *1	, UP±ddd.dddd
Reference value *3	, REF±ddd.dddd
Scale value	, SCLc
Positive preset *4	, PS±ddd.dddd
Negative preset *4	, PSM±ddd.dddd
Data output condition *5	, PRr
Periodic data output timer	, PRT ttt

Number of sample measurements		, SMP nnn
Sample measurement	• Maximum value *6	, MAX
	• Minimum value *6	, MIN
	• Range *6	, RNG
	• Mean *6	, AVG
Group size subject to judgment *2		, GN nn
Lower tolerance limit of group judgment *2		, GLL±ddd.dddd
Upper tolerance limit of group judgment *2		, GLH±ddd.dddd
Statistical items for group judgment	: Maximum value *2, 6	, GMX
	: Minimum value *2, 6	, GMN
	: Mean *2, 6	, GAG
	: Range *2, 6	, GRG

(b) Description: This sets the measuring conditions.
- Each of the commands that follow the SET command must be delimited by a comma (,).
- A command which doesn't need a setting change can be eliminated.
- Approximately 0.5 second is required for this command to be processed.

(c) Example: Reception command SET, SG2, M4, LL$_{\Delta}$ 5.988, LH$_{\Delta}$ 6.010, REF0

*1: Select either setup method in the basic setup.

*2: This is valid only if the function is specified in the basic setup.

*3: This is valid only if the "Copying the target value to the reference value" is specified in the basic setup.

*4: Set the reference gage on the Measuring Unit before sending this command. These commands will spend several seconds for processing. The settings of each function are as follows:
- Positive preset: Presetting in the positive (0) direction.
- Negative preset: Presetting in the negative (1) direction.

*5: "PRr" is used to set the data output conditions for the RS-232C (printer)/GP-IB or Digimatic Output Unit. If the PR number is 1, 3 or 5, it is possible to set the periodic output timer, and the data output interval can be selected from 0 (for each measurement) and between 1 and 999 seconds.
The PR numbers and the data output conditions have the following relationships.

Data output condition (PR No.)	RS-232C GP-IB DCU	Printer	Remark
0	—	—	
1	—	○	The periodical output timer can be set
2	—	△	
3	○	—	The periodical output timer can be set
4	△	—	
5	○	○	The periodical output timer can be set
6	△	△	
7	—	□	
8	□	—	
9	□	□	

○ : Outputs data for each measurement.
△ : Performs measurement and outputs data when a GO measurement results.
□ : Performs measurement and outputs data when a ±NG measurement results.
— : No output

*6: Only one of these statistical items can be specified.

(14) R

(a) Format: R
(b) Description: If the number of samples is set between 1 and 999, this command executes single-run measurement and transmits the measurement result in conformity with DATA FORMAT as the response command.
(c) Example: Reception command R
Response command P00, 12.3456

(15) CR, CL

(a) Format: CR
CL
(b) Description: CR: If the number of samples is set between 1 and 999, this command executes continuous-run measurement. However, it does not respond to the "CR" command.
• It transmits the measured results in conformity with DATA FORMAT for the response command.
CL: Terminates continuous-run measurement.
(c) Example: Reception command Response command
CR None
• Outputs as the response, the measurement results according to the data output conditions in conformity with DATA FORMAT.
CL OK

(16) R, STOP

(a) Format: R
STOP
(b) Description: R: If the number of samples is set to 0, this command executes zero-run measurement. However, it does not respond to "R" command.
STOP: Terminates the zero-run measurement, and transmits the measurement results in conformity with DATA FORMAT as the response.
(c) Example: Reception command R
STOP
Response command P00, 12.3456

(17) D

(a) Format: D
(b) Description: Transmits as the response the last display of data in the ready state or latched data not in conformity with DATA FORMAT.
This command is used to transmit the previous data, while the R command is used to execute measurement then the results are transmitted.
(c) Example: Reception command D
Response command (DATA FORMAT)

(18) ST, NST

(a) Format: ST
NST
(b) Description: ST : Performs statistical processing. However, measurements obtained in the ready state will be omitted from the objectives of statistical processing.
NST: Terminates the statistical processing.
(c) Example: Reception command ST or NST
Response command OK

(19) MC, MCAL

(a) Format: MC
MCAL

(b) Description: Both the MC and MCAL commands are used to clear the statistical memory. This operation is required before starting statistical processing.

(c) Example:
Reception command MC or MCAL
Response command OK

(20) STAT

(a) Format: STAT

(b) Description: Requests the statistical processing data. The statistical processing data will be cleared when the power is off.

(c) Example:
Reception command STAT
Response command STAT␣ DATA, P00, N100, AVG12.0001, MAX12.0005, MIN11.9998, RNG0.0007, S.D0.00007

(21) AUT

(a) Format: AUT, Nmmm, Dtttt, L±ddd.dddd, H±ddd.dddd

(b) Description: Set the conditions of automatic workpiece detection with the following data to follow "AUT" and delimited by a comma (,).
Lower and upper detection limits for the position detection method do not require a "-" sign, so it will be ignored if specified.

- Responds only when the automatic workpiece detection has been set in the basic setup.
- N mmm (mmm: number of measurement times between 1 and 999. If "0" is specified, automatic workpiece detection is not performed.)
- Dtttt (tttt: Invalidation period between 0 and 9999 ms)
- L±ddd.dddd (±ddd.dddd: Lower detection limit)
- H±ddd.dddd (±ddd.dddd: Upper detection limit)

(c) Example:
Reception command AUT, N50, D15, L9.5, H12.3
Response command OK

(22) AUT, S

(a) Format: AUT, S

(b) Description: Where "Performing the automatic workpiece detection" is specified in the basic setup, and if this command is received, "S" will be responded each time a workpiece is detected.
If this setup is not made in the basic setup, designating this command results in ER6.

(c) Example:
Reception command AUT, S
Response command OK

(23) RA

(a) Format: RA

(b) Description: Transmits as the response the conditions of the automatic workpiece detection using RA FORMAT.

(c) Example:
Reception command RA
Response command AUT, N50, D15, L9.5, H12.3

(24) PR

(a) Format: PR

(b) Description:
- Dedicated command for GP-IB.
- Used to print the measured data on the optional printer.
- It is necessary to set the RS-232C port to the printer port in the basic setup in advance. Without this setup, designating this command results in ER6.

(c) Example: Reception command PR
Response command None (printed on the printer)

(25) SRQ, NSRQ

(a) Format: SRQ, NSRQ

(b) Description:
- Dedicated command for GP-IB.
- This is used to set up the service request transmission, according to the data condition or command receiving condition.
- Using an SRQ, the interface unit performs a service request to the controller. With the NSRQ, the interface will not perform service request.
- A response command will not be issued to this SRQ. Acknowledge if the response is OK with the SRQ status byte.
- With the NSRQ, the interface will not perform service request. It will only respond with an "OK" command.

(26) Timing signal

If the measuring operation is interrupted by a command from the I/O interface or key operation, an ER7 will be responded to the RS-232C/GP-IB interface.
This can be used as a timing signal to start a sequencer, etc.

6.2 Optional Interface

Into the option slot either of the Digimatic Code Output Unit, Second I/O Analog, BCD, and GP-IB Interface Units can be mounted.

It is also possible to perform measurement with two Measuring Units at a time if the optional dual-type add-on unit is mounted on them.

6.2.1 Digimatic Output Unit interface

With the optional Digimatic Output Unit interface the LSM can be connected to the Digimatic Data Processor (DP-1VR) which uses the Mitutoyo-original data format for easy data collection and processing.

In addition, as this LSM has two interface units, two pairs of measurements can be collected at a time, if the simultaneous measurement is specified.

6.2.1.1 Method of use

1) Installation and setup of the interface

- Install the interface unit in the Display Unit. For the method of installation, refer to Section 6.3 “Installing the Optional Interface Unit”.
- In the B6 mode of the basic setup, make the settings for the Digimatic Output Unit interface.

DCU1 : Uses only the OUTPUT-1 from the two interface units.
Select this mode for single measurement.

BOTH : Uses the OUTPUT-1 and OUTPUT-2 interface units.
Select this mode when two Digimatic Output Units are used for simultaneous measurement.

- Set the data output conditions in the function setup.

Data output condition	RS-232C GP-IB DCU	Printer	Remark
0	—	—	
1	—	○	The periodical output timer can be set
2	—	△	
3	○	—	The periodical output timer can be set
4	△	—	
5	○	○	The periodical output timer can be set
6	△	△	
7	—	□	
8	□	—	
9	□	□	

○ : Outputs data for each measurement.
△ : Performs measurement and outputs data when a GO measurement results.
□ : Performs measurement and outputs data when a ±NG measurement results.
— : No output

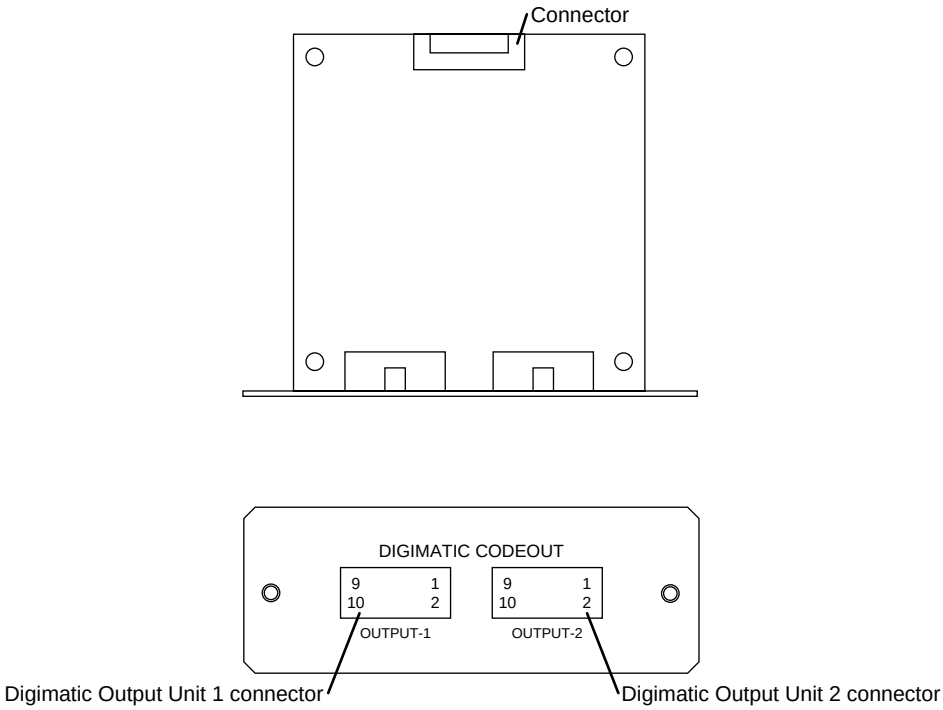
2) Data output

a. When a data send request comes from the external equipment such as the Digimatic Data Processor to the LSM, the measurement data will be outputted through this interface by the following timing.

- When the DATA key on the Digimatic Data Processor is pressed
- When the foot switch being connected to the Digimatic Data Processor is pressed.
- When an $\overline{\text{REQ}}$ signal is inputted from other external equipment.

b. When the measurement is initiated by pressing the RUN key, or by receiving a $\overline{\text{RUN}}$ input from the I/O interface or "R" command from the RS-232C/GP-IB interface, the measurement data will be outputted according to the data output conditions being set.

6.2.1.2 Name of each part

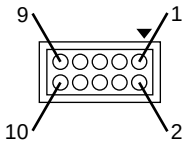


Consisting of	Quantity
Digimatic Output unit	1
Connecting cable	1

6.2.1.3 I/O specifications

The following are the I/O specifications of the Digimatic code output interface.

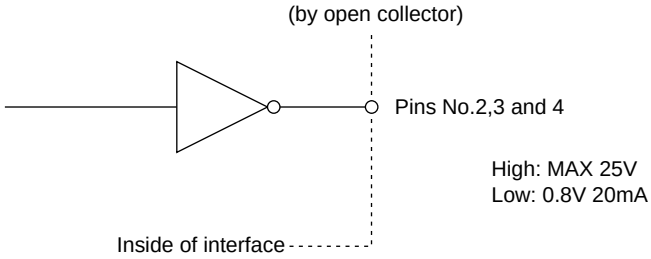
- Applicable connector: 7910-B500 (Manufacturer: 3M)
  XG4M-1030 (Manufacturer: Omron)



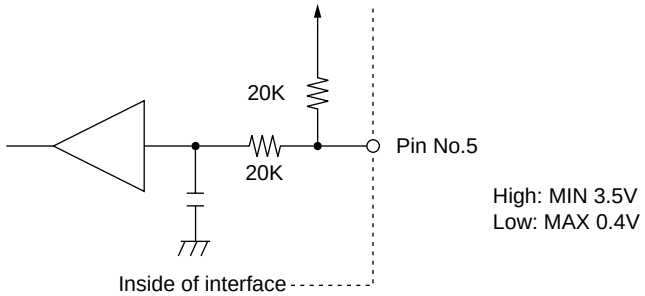
- Pin assignment

Pin No.	Signal name	I/O direction	Function
1	GND	—	Signal GND
2	DATA	Out	Data out
3	$\overline{\text{CK}}$	Out	Data transmission clock
4	$\overline{\text{RDY}}$	Out	Data read request for external device
5	$\overline{\text{REQ}}$	In	Data output request from external device
6~9	I.C	—	Spare
10	F.G	—	Frame GND

- Signal output circuit

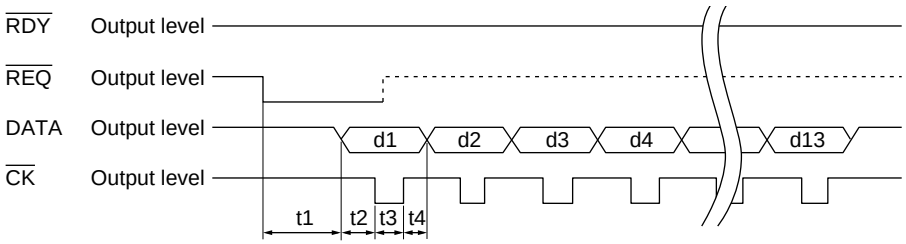


- Signal input circuitry



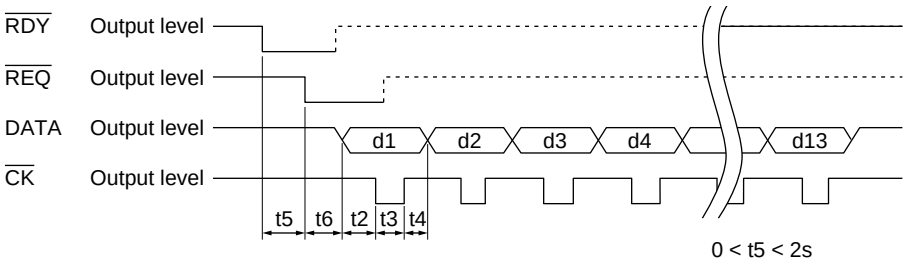
6.2.1.4 Timing chart

1) When a data request is transmitted from a Digimatic data processor to the LSM



t1: 20 ms or less (measurement time if successively requested)
t2: 0.2 to 1 ms
t3: 0.2 to 1 ms
t4: 0.2 to 1 ms

2) When a data read request is transmitted from the LSM to the Digimatic data processor



0 < t5 < 2s
t6: 0 to 120 ms
t2: 0.2 to 1 ms
t3: 0.2 to 1 ms
t4: 0.2 to 1 ms

TIP

- The DP-series Digimatic Data Processor takes approximately 2 seconds for processing each data. Therefore, do not issue a data output request at an interval less than 2 seconds.
- Data will not be outputted while an error message is shown on the LSM display.
- If the Digimatic Data Processor shows an error message, check the number of digits (of the sent data) below decimal point. For detail refer to Section 6.2.1.5 “Data format”.
- If the DP-1VR is connected, set the “INTERFACE” setting of the DP-1VR to “COMPATIBLE”. For details, refer to the user’s manual of “DP-1VR”.

6.2.1.5 Data format

Digimatic data format consists of measured data which is made up of 13 hexadecimal digits using 0 to F, each 4 bits (of binary data) long. The data is output serially, starting from the LSB (Least Significant Bit) of the LSD (Least Significant Digit) to the MSB (Most Significant Bit) of the MSD (Most Significant Digit). The 13 digits have the following content.

Digit	Function	Bit configuration
d1 d2 d3 d4	Unassigned	F (1111) F (1111) F (1111) F (1111)
d5	Sign	+ : 0 (0000) - : 8 (1000)
d6 d7 d8 d9 d10 d11	Measured data (6 digits of BCD)	MSD LSD
d12	Decimal point position	X 10 $^{-0}$: 0 (0000) X 10 $^{-1}$: 1 (0001) X 10 $^{-2}$: 2 (0010) X 10 $^{-3}$: 3 (0011) X 10 $^{-4}$: 4 (0100) X 10 $^{-5}$: 5 (0101)
d13	Unit (GO/±NG judgment results)	mm : 0 (0000) inch : 1 (0001) mm (+NG) : 2 (0010) mm (GO) : 3 (0011) mm (-NG) : 4 (0100) inch (+NG) : 5 (0101) inch (GO) : 6 (0110) inch (-NG) : 7 (0111)

An example of output data

d1	d2	d3	d4	d5	d6	d7	d8	d9	d10	d11	d12	d13
F	F	F	F	0	2	1	0	7	6	5	4	0

d5 d6~d11 d12 d13

+ 210765 x 10 $^{-4}$ mm

→ +21.0765mm

NOTE 1. Decimal Point Position

The decimal point position will be adjusted as follows for the DP series data processor, which handles 6-digit data.

- If the uppermost (7th) digit of the output data is 0, the lower six digits will be output.
- If the uppermost (7th) digit of the output data is not 0, data “999999” will be output.
- If six digits are in the decimal places, a “0” is output as a decimal point position.

Example)

Display	Digimatic code output	
	Transmitted data	Decimal point position
5.4321	054321	4
65.4321	654321	4
765.4321	999999	4
0.654321	654321	0
7.654321	765432	5

2. Data output at simultaneous measurement

If two Digimatic Output Units are used in simultaneous measurement, outputs to each Digimatic Output Units are as follows:

- OUTPUT-1: Data from program Nos. 0 through 4
- OUTPUT-2: Data from program Nos. 5 through 9

If a single Digimatic Output Unit is used, it must be connected to OUTPUT-1, through which data of the foreground program is outputted.

6.2.2 Second Analog I/O Interface

This interface deals with two pairs of GO/NG judgment result output, one set of analog output and control input. This is suitable for simultaneous measurement, multi-limit selection, and group judgment operations.

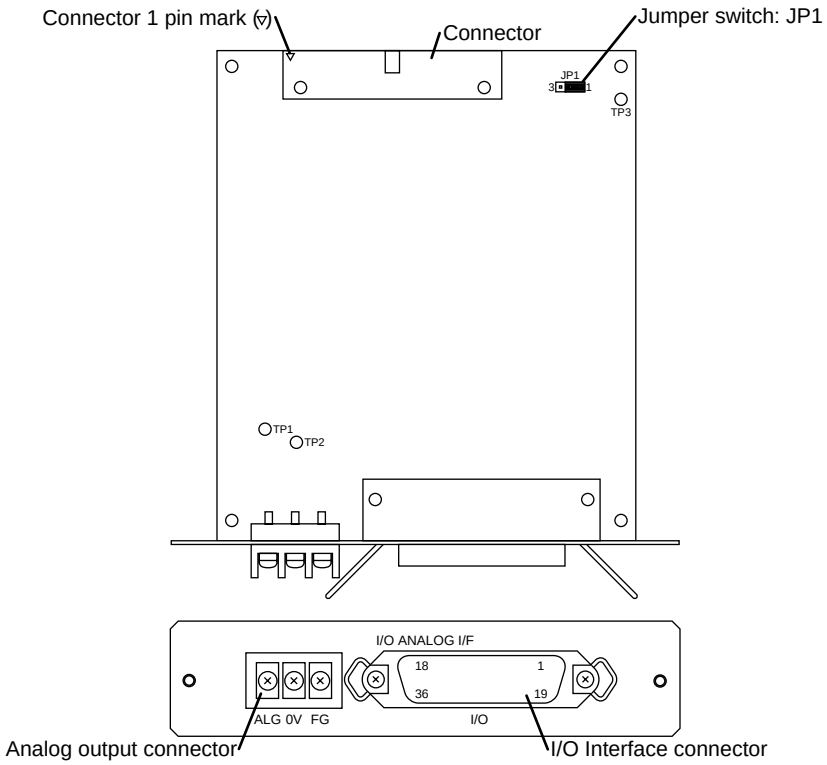
6.2.2.1 Method of use

1) Installation and setup of the interface

- Install the interface unit in the Display Unit. For the method of installation, refer to Section 6.3 “Installing the Optional Interface Unit”.
- In the basic setup make the settings according to the purpose of measurement. For detail refer to Section 4.1 “Basic Setup”.
- In the function setup make the settings according to the purpose of measurement. For detail refer to Section 4.5 “Setting Up the Functions”.

NOTE This interface has jumper pins (for short-circuiting between Pins 1 and 2 of JP1) on the upper surface of the board. However, never modify the existing setting, since this is for future expansion.

6.2.2.2 Name of each part



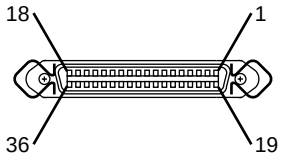
Consisting of	Quantity
Second Analog I/O interface	1
Connector	1
Connecting cable	1

6.2.2.3 I/O Interface

This interface is used to communicate with a sequencer, a PC (programmable controller), or relay circuitry by means of sequential signals. The signal has negative-true logic (output level is LOW when control is ON). (Only Err-0 has positive-true logic.)

1) Specifications

• Pin assignment



Applicable connecter
57-30360 (or the equivalent product by DDK or Amphenor, etc.)
This is the standard accessory of this interface.

a. Pin assignment

Pin No.	Signal name		I/O direction	Pin No.	Signal name		I/O direction
1	+5V (Internal power)		—	19	GND (Internal power)		—
2	COM (IN)		—	20	COM (IN)		—
3	$\overline{b0}$	$\overline{P0}$	IN	21	$\overline{b1}$	$\overline{P1}$	IN
4	$\overline{b2}$	$\overline{P2}$	IN	22	$\overline{b3}$	$\overline{P3}$	IN
5	$\overline{PRG}$	$\overline{P4}$	IN	23	$\overline{B\_L7}$		OUT
6	$\overline{SHIFT}$		IN	24	$\overline{PRINT}$		IN
7	$\overline{RUN}$	$\overline{T.RUN}$	IN	25	$\overline{RESET}$		IN
8	$\overline{(A\_-NG)}$	$\overline{A\_L1}$	OUT	26	$\overline{(A\_GO)}$	$\overline{A\_L2}$	OUT
9	$\overline{(A\_+NG)}$	$\overline{A\_L3}$	OUT	27		$\overline{A\_L4}$	OUT
10		$\overline{A\_L5}$	OUT	28		$\overline{A\_L6}$	OUT
11	$\overline{B\_-NG}$ $\overline{GTJ\_-NG}$	$\overline{B\_L1}$	OUT	29	$\overline{B\_GO}$ $\overline{GTJ\_GO}$	$\overline{B\_L2}$	OUT
12	$\overline{B\_+NG}$ $\overline{GTJ\_+NG}$	$\overline{B\_L3}$	OUT	30		$\overline{B\_L4}$	OUT
13		$\overline{B\_L5}$	OUT	31		$\overline{B\_L6}$	OUT
14	$\overline{A\_+NG}$	$\overline{A\_L7}$	OUT	32	$\overline{A\_-NG}$	$\overline{(A\_L1)}$	OUT
15	$\overline{A\_GO}$	$\overline{(A\_L2)}$	OUT	33	$\overline{ACK}$		OUT
16	ER0		OUT	34	$\overline{STB}$		OUT
17	COM (OUT)		—	35	COM (OUT)		—
18	$\overline{CNT}$		OUT	36	FG		—

NOTE
- Between Pin No.8 and Pin No.32, between Pin No.15 and Pin No.26, between Pin No.2 and Pin No.20, and between Pin No.17 and Pin No.35 are connected internally.
- When the 100 program method is selected, use the signal “b0” to “b3” and “PRG” to select the program number.
- When the 10 program method is selected, use the signal “P0” to “P4” to select the program number.
  100 or 10 program method is selected in the Expanded Basic setup.
- In single measurement judgment, results will be outputted to “A” and “B”.
- In simultaneous measurement, judgment result from the program Nos.x0 to x4 will be outputted to “A”, and that from the program Nos.x5 to x9 will be outputted to “B”, respectively.
- When group judgment is selected, each individual judgment result will be outputted to “A”, and the group judgment result will be outputted to “GTJ” (“B”).
- When “LL-LH” or “N-UL” method is selected, “+NG”, “GO”, “-NG” are used to output of judgment.
- When “L1-L6” method is selected, “L1” to “L7” are used to output of judgment. Method of judgment is selected in the Basic setup.

2) Input signal

Signal	Description
$\overline{\text{RESET}}$	Clears the result display or interrupts measurement.
$\overline{\text{RUN}}$	Used to start signal run measurement when “5 RUN” is set to “S.RUN” or “C.RUN”. Used to start and stop zero run measurement when “5 RUN” is set to “S.RUN” or “C.RUN” Used as “T.RUN” type input signal when “5 RUN” is set to “T.RUN”. They are selected by the Basic setup
$\overline{\text{RUN}}$ + $\overline{\text{RESET}}$	Used to start continuous run measurement when “5 RUN” is set to “S.RUN” or “C.RUN”.
/b0 to 3 + $\overline{\text{PRG}}$ /b0 to 3 + $\overline{\text{SHIFT}}$ + $\overline{\text{PRG}}$	To select program number Px0 to Px9. To select channel number P0x to P9x.
/P0 to 4 $\overline{\text{SHIFT}}$ + /P0 to 4	To select program number P0 to P4 when “7 PRGM” is set to “10”. To select program number P5 to P9 when “7 PRGM” is set to “10”.
$\overline{\text{SHIFT}}$ + $\overline{\text{RUN}}$	PSET: Presetting will be performed using the already set preset value and preset direction If those Preset conditions are not set, zero-setting in. HOLD: Can be set as “HOLD” signal by the basic setup (“5 PSET”).
$\overline{\text{PRINT}}$	Used to printout the measurement result when “4 RS-232C” is set to “PRN” by the basic setup.
$\overline{\text{PRINT}}$ + $\overline{\text{RESET}}$	The statistical processing results will be printed, and then all statistical memory will be cleared.
$\overline{\text{SHIFT}}$ + $\overline{\text{RESET}}$	The “ER7” command will be output from the RS-232C. Use this as a timing signal.

NOTE All input signal must be off before the new input signal is on.
During measurement only “RESET”, “RUN” (as stop), “PRINT” or “HOLD” signals are accepted.

3) Input signal to select program number

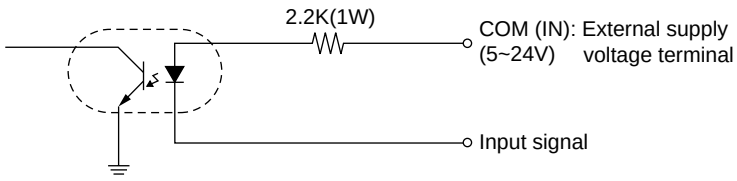
/b0	/b1	/b2	/b3	/SHIFT	/PRG	Description
Off	off	off	off	off	on	Select program number Px0
On	off	off	off	off	on	Select program number Px1
Off	on	off	off	off	on	Select program number Px2
On	on	off	off	off	on	Select program number Px3
Off	off	on	off	off	on	Select program number Px4
On	off	on	off	off	on	Select program number Px5
Off	on	on	off	off	on	Select program number Px6
On	on	on	off	off	on	Select program number Px7
Off	off	off	on	off	on	Select program number Px8
On	off	off	on	off	on	Select program number Px9
Off	off	off	off	on	on	Select channel number P0x
On	off	off	off	on	on	Select channel number P1x
Off	on	off	off	on	on	Select channel number P2x
On	on	off	off	on	on	Select channel number P3x
Off	off	on	off	on	on	Select channel number P4x
On	off	on	off	on	on	Select channel number P5x
Off	on	on	off	on	on	Select channel number P6x
On	on	on	off	on	on	Select channel number P7x
Off	off	off	on	on	on	Select channel number P8x
On	off	off	on	on	on	Select channel number P9x

NOTE All input signal must be off before the new input signal is on.
However, signal “b0” to “b3” and “SHIFT” is able to be on before signal “PRG” is on.

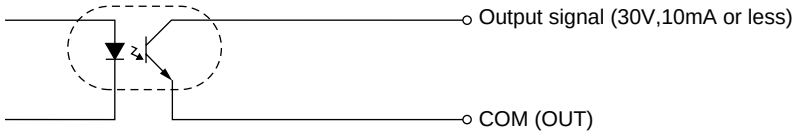
4) Output signal

Signal	Description
$\overline{\text{A\_-NG}}$, $\overline{\text{A\_GO}}$, $\overline{\text{A\_+NG}}$ $\overline{\text{A\_L1\_to\_L7}}$	• Output of GO/-NG judgment result when “1 JDG.M” is set to “LL-LH” or “N-UL”. • And multi-limit judgment result when “1 JDG.M” is set to “L1-L6”. • Data for program Px0 to Px4 will be output in the simultaneous-program measurement.
$\overline{\text{B\_-NG}}$, $\overline{\text{B\_GO}}$, $\overline{\text{B\_+NG}}$ $\overline{\text{B\_L1\_to\_L7}}$	• Output of GO/-NG judgment result when “1 JDG.M” is set to “LL-LH” or “N-UL”. • And multi-limit judgment result when “1 JDG.M” is set to “L1-L6”. • The output signal is equivalent to “A” in the signal-program measurement. • Data for program Px5 to Px9 will be output in the simultaneous-program measurement. • Single or simultaneous-program measurement are selected by basic setup (“2 PROG”).
ER0	• This is usually set to ON (LOW level) but turns to OFF (HIGH level) when a segment error occurs.
$\overline{\text{GTJ\_-NG}}$, $\overline{\text{GTJ\_GO}}$, $\overline{\text{GTJ\_+NG}}$	• Outputs the results of group in group judgment. (Basic setup “3 GTJ”=“USE”)
$\overline{\text{ACK}}$	• This is set to ON (LOW level) during measurement (single-run or continuous-run).
$\overline{\text{STB}}$	• Before outputting a judgment result, this will be output (Low) as a cofirming signal.
$\overline{\text{CNT}}$	• Turns Low level if abnormal data to be discarded occurred successively. • It is need the setting of “2 CNT” by Function setup. And “3 ADE” is set to “USE” or “USE2” by Basic setup.

• Input circuitry



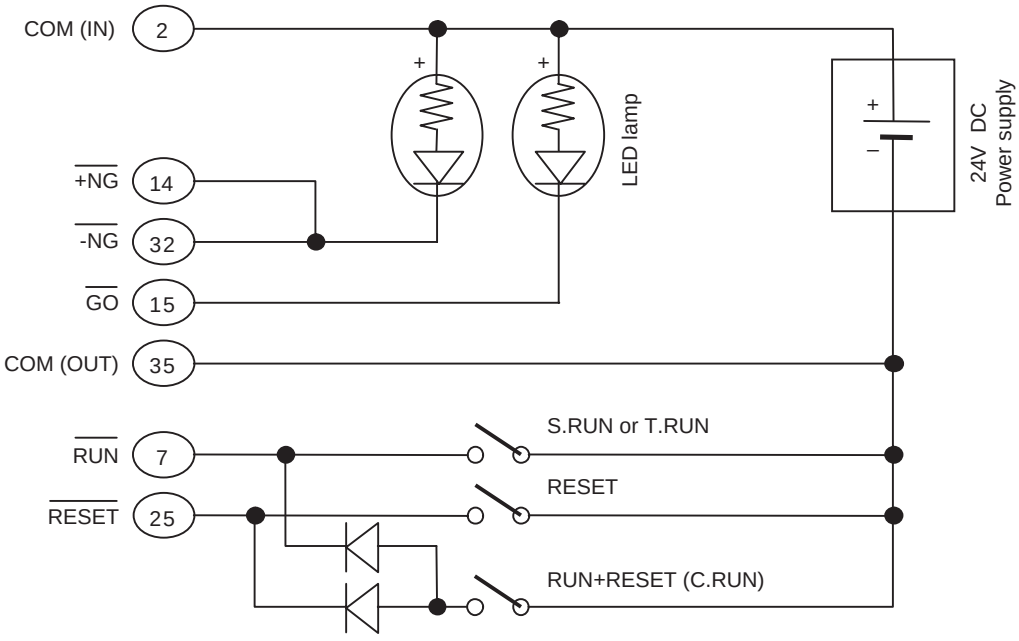
• Output circuitry



5) Power supply for external devices (+5V, GND)

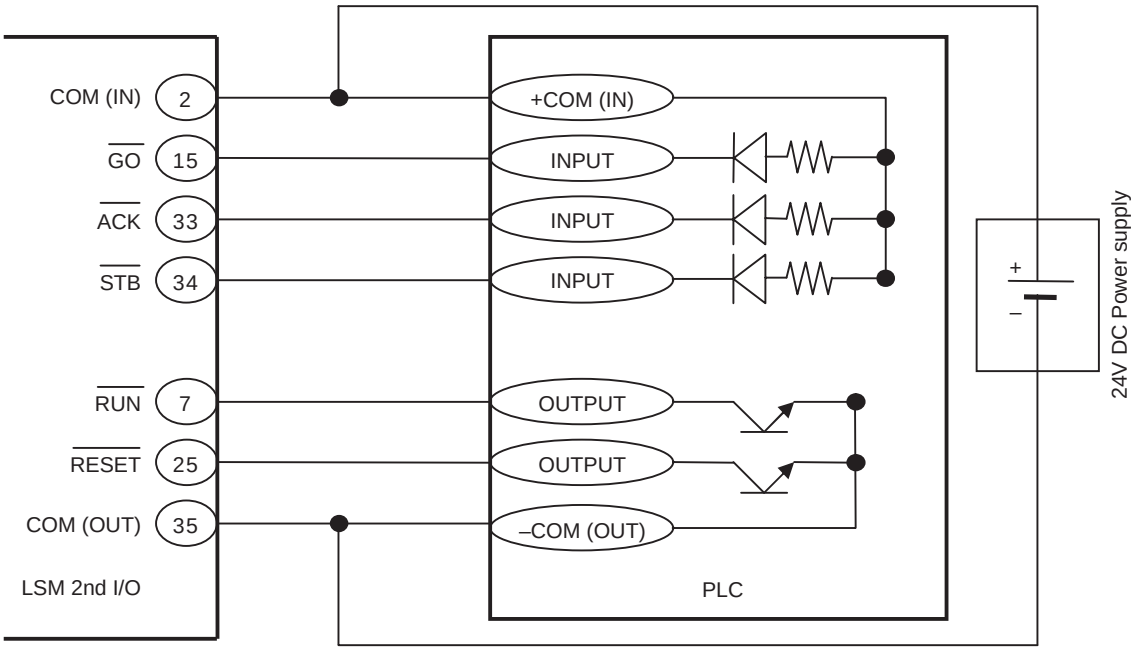
This terminal supplies 5V 100mA for input signal. This is able to use only testing for input signals.

6) Example for Switch and LED lamp



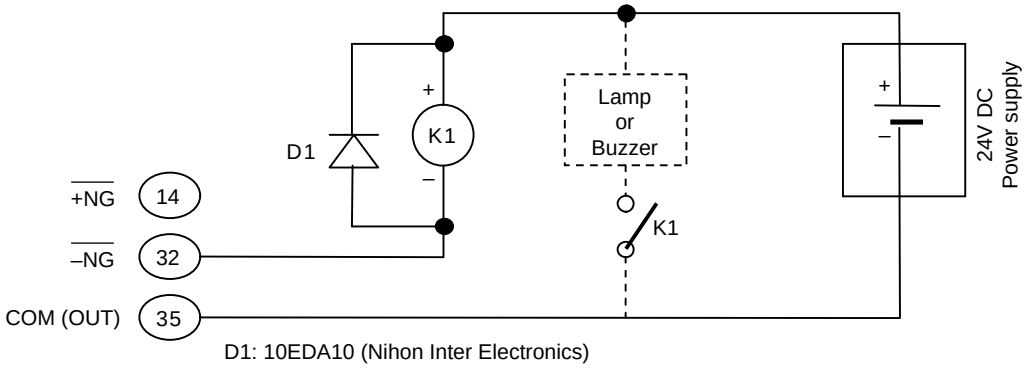
10EDA10 (Nihon Inter Electronics)

7) Example for PLC (Programmable Logic sequence Controller)



- The input of PLC must be plus common type.
  The output of PLC must be minus common type.
- There must be Transistor type input or output. Do not use Reray type.

8) Example for High sensitivity relay



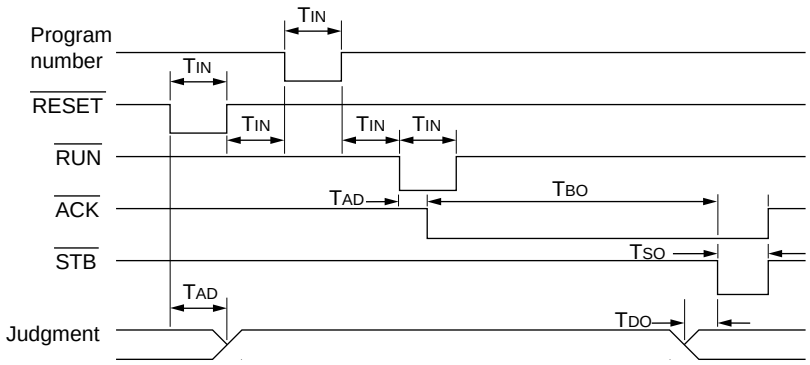
D1: 10EDA10 (Nihon Inter Electronics)

TIP

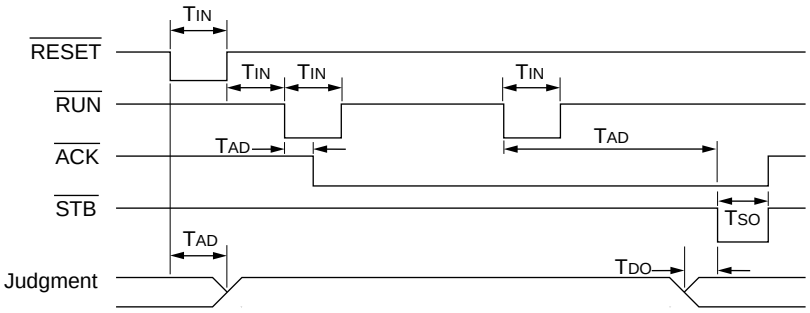
- When Err-0 occurs, judgment output are all set to OFF.
- The single-run measurement and zero-run measurement will be interrupted by Err-0 and the measurement mode will be terminated without outputting the results.
- During the continuous-run measurement, the ACK is set to ON, even if an Err-0 occur. Measurement continues after the error is rectified.

9) I/O timing chart

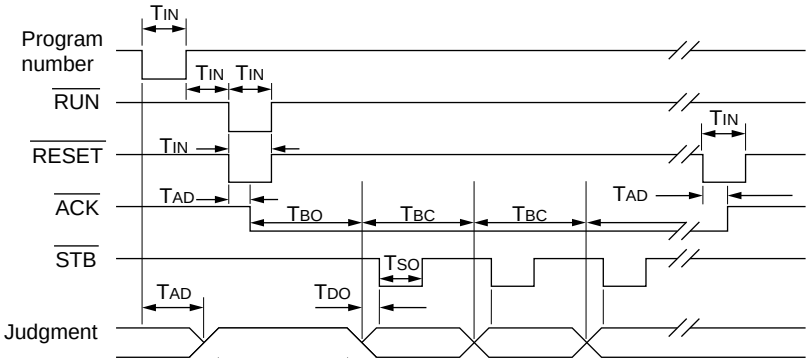
• Single-run measurement



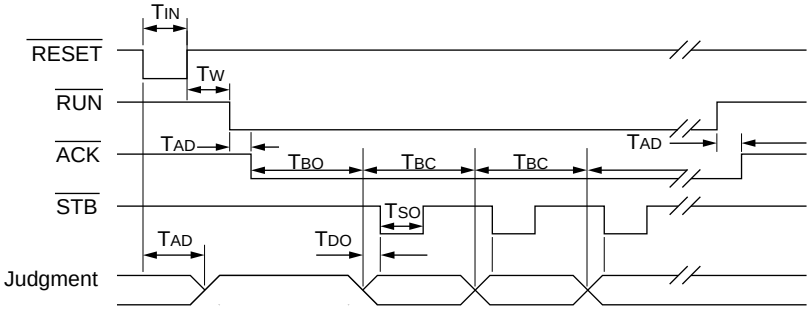
• Zero-run measurement



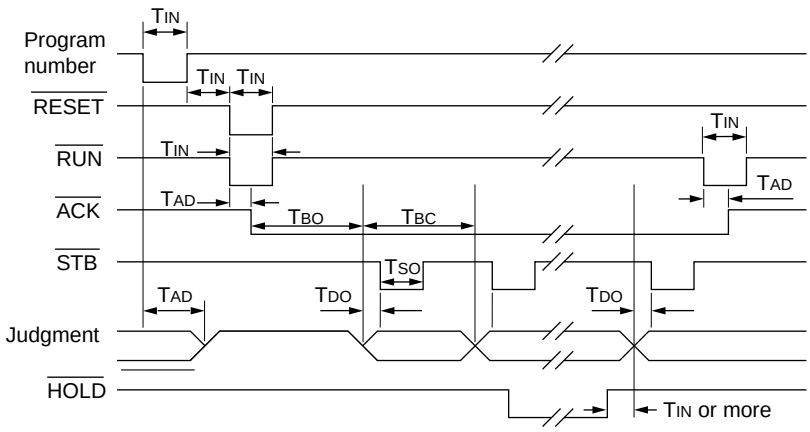
• Continuous-run measurement



• Continuous-run measurement with term specification



• Timing of HOLD input (at continuous-run measurement)



• Response time

Item	Response time	Description
TIN	> (Tif x 2 + 3 ms)	Input time
TAD	< (Tif x 2 + 3 ms)	Acceptance time
Ter	< (Tif / 2)	Permission of error of same-timing
Tif	5 ms, 2 ms, 20 ms Can be selected by Expanded basic setup (“7 IFF”)	Delay time by filter
TSO	Refer to next page, Strobe length (TSO).	Strobe length
TDO	0.05 ms to 0.2 ms	Data setup time
TBO	< (Tmr x N + 3 ms) “Tmr x 2” might increase for dual unit measurement.	Duration of Single-run measurement
TBC	< (Tmr x N + 1 ms)	Duration of continuous-run measurement
TBD	< (Tmr + 1 ms)	Duration of ready state
Tmr	Refer to next page, Measurement interval (Tmr).	Measurement interval
N	Refer to Section 9.2.4, Number of samples (“6 SMP N”). And refer to Section 4.5.3.8, Number of samples (“6 SMP N”).	Number of samples (SMP N)

NOTE In order to input multiple signals at same time, the interval between the input signals must be “Ter” or less.

• Measurement interval (Tmr) and Strobe length (Tso)

Number of scans for averaging: MR	Measurement interval: Tmr (for Series LSM-500S)	Strobe length: Tso
2048	640 ms ± 20 %	20 ms ± 20 %
1024	320 ms ± 20 %	
512	160 ms ± 20 %	
256	80 ms ± 20 %	
128	40 ms ± 20 %	2 ms ± 20 %
64	20 ms ± 20 %	
32	10 ms ± 20 %	
16	5 ms ± 20 %	
8	2.5 ms ± 20 %	0.3 ms ± 20 %
for Moving average excluded first averaging of measurement	5 ms ± 20 %	2 ms ± 20 %

NOTE
- Might increase the timing value by the lord of circuit.
- “Tso” is able to select fixed value “0.1 ms” to “100 ms” by Expanded basic setup (“7 STB”)
  It is only effect in the Single-run-measurement, Zero-run-measurement and continuous-run-measurement.

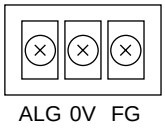
6.2.2.4 Analog output

Measurement results will be outputted as full-scale ±5V analog signals.

LSM has two analog outputs. First is standard analog I/O interface. Second is this optional 2nd Analog I/O interface.

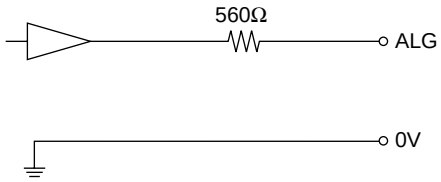
1) Specification

- Pin assignment



Pin No.	Signal name	Description
1	ALG	Analog output terminal
2	0V	Analog 0V terminal
3	FG	Frame ground (grounding terminal)

- Output circuit



a. Range of analog output voltage is ±5V.
b. The accuracy of the analog output voltage is 0.2% of its full scale.
c. This analog output must be connected to a device that has an input impedance of 1 MΩ or greater. If the input impedance is low, the output accuracy will be reduced.

2) Method of use

- Set a proper reference value and scale value in the function setup. However, if "Copying the target value to the reference value" is set in the basic setup, set the target value instead of reference value.
- (Analog output) = (Measured data) - (Reference value) x (gain)
  For detail refer to Section 4.5.3.4 "F3: Setting the reference value".
- In the normal measurement mode, first and second analog output is same output data.
- In the simultaneous mode, the analog output of program Px0 to Px4 will be made via the first, and that of program Px5 to Px9 will be made via the second.
- Set the analog output voltage in the event of Err-0 by the basic setup ("1 ERR-0V").

NOTE
1. Always use a braided shielding wire cable as the analog cable, and positively ground the braided shielding wire to the FG terminal.
2. If wiring the Analog output connector, do not directly touch the output terminals by hand, which has static charges, because the internal circuit may be damaged by static discharge. Discharge the static energy by touching the metallic surface of the Display unit in advance. In addition, unplug the power cord from the outlet before commencing wiring.
3. After wiring has been completed, close the protective cover.

6.2.3 BCD interface

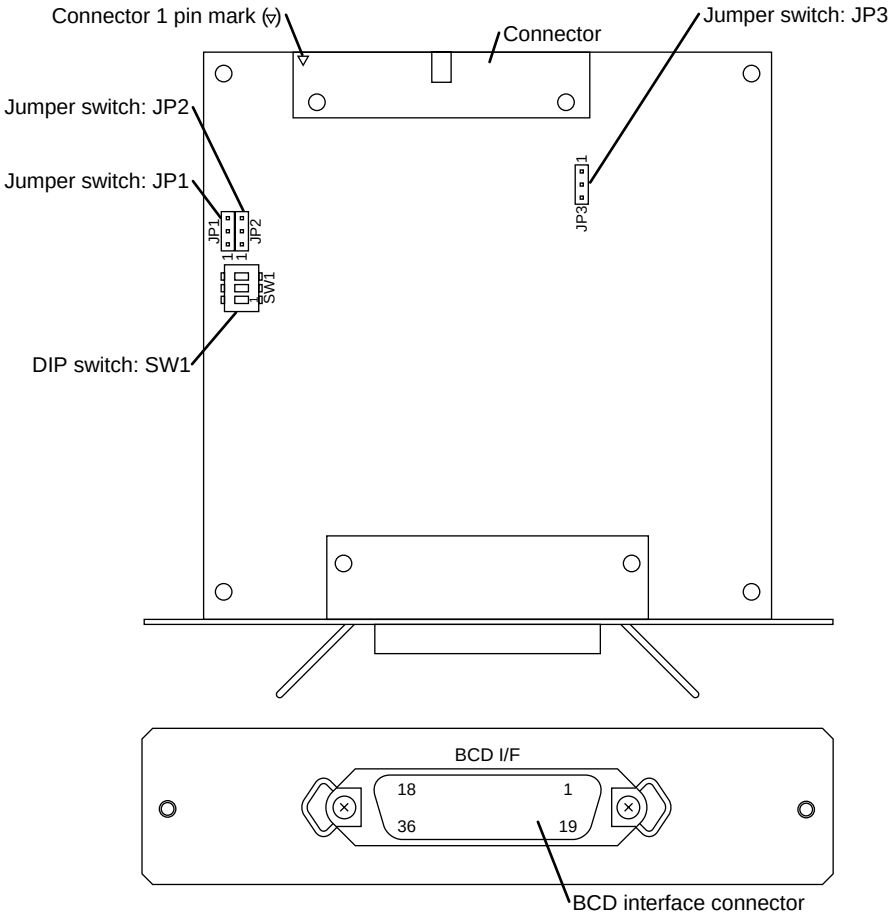
This interface outputs data in parallel format. The output data consists of a positive true logic/negative true logic signal and a decimal number (BCD)/Hexadecimal number (HEX).

6.2.3.1 Method of use

1) Installation and setup of the interface

- By referring to Section 6.2.3.3 “Specification”, set the jumper switches and DIP switches to meet the purpose of measurement.
- Install this interface unit in the Display Unit. For the installation method, refer to Section 6.3 “Installing the Optional Interface Unit”.

6.2.3.2 Name of each part

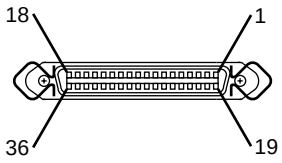


Consisting of	Quantity
BCD interface	1
Connector (57-30360)	1
Connecting cable	1

6.2.3.3 Specification

1) BCD specifications

- Pin assignment

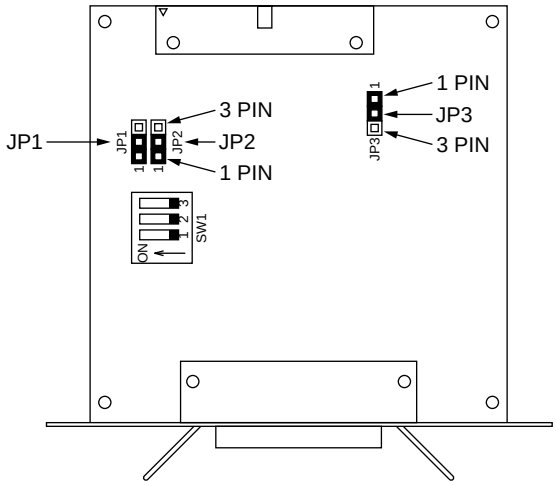


Pin No.	Signal name	Pin No.	Signal name	Pin No.	Signal name
1	1 } X 10 0	13	1 } X 10 3	25	1 } X 10 6
2	2	14	2	26	2
3	4	15	4	27	4
4	8	16	8	28	8
5	1 } X 10 1	17	1 } X 10 4	29	Err-0 (segment error)
6	2	18	2	30	HOLD (input)
7	4	19	4	31	$\overline{F}$/R (Switching foreground / background)
8	8	20	8	32	$\overline{STB}$ (strobe output)
9	1 } X 10 2	21	1 } X 10 5	33	EXT.Vcc (power supply for external device)
10	2	22	2	34	+POLE (polarity display)
11	4	23	4	35	GND (signal GND)
12	8	24	8	36	FG (Frame GND)

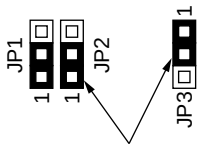
- Applicable connector
  57-30360 (or the equivalent product by DDK or Amphenor, etc.)
  This is the standard accessory of this interface.

2) Selection of functions to be used

- Selection of jumper switches

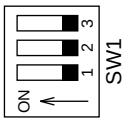


• Jumper switch



Make between No. 1 and 2 pins or between No.2 and 3 pins short-circuited using a short-circuiting plug.

• DIP switch



Select a positive true logic/negative true logic signal and a decimal number (BCD)/ Hexadecimal number (HEX) for the data output.

Jumper pin No.	Jumper setting	Function
JP1	Short-circuiting between 1 and 2 (factory setting)	Positive-true logic
	Short-circuiting between 2 and 3	Negative-true logic
JP2	Short-circuiting between 1 and 2 (factory setting)	Output of a decimal number (BCD)
	Short-circuiting between 2 and 3	Output of a hexadecimal number (HEX) Note
JP3	Short-circuiting between 1 and 2 (factory setting)	Negative-true logic For future expansion, Always short-circuit between 1 and 2.
	Short-circuiting between 2 and 3	

Note: Outputs the displayed measured data in a hexadecimal number (HEX)

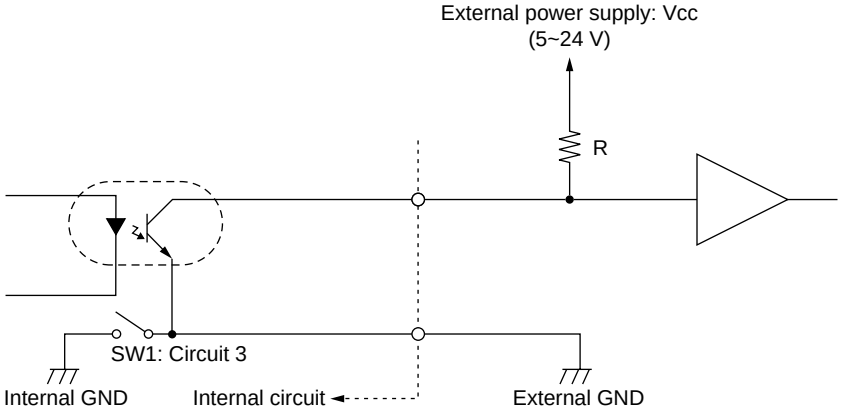
- DIP switch settings

Circuit No.	Switch setting	Function
Circuit 1	OFF (factory setting)	For future expansion. Never turn to ON, otherwise an operation error occurs.
	ON (prohibited)	
Circuit 2 Note 1	OFF (factory setting)	Uses the external power supply.
	ON	Uses internal power and +5V power supply (max. 100 mA)
Circuit 3 Note 1	OFF (factory setting)	Separates between the internal and external grounds.
	ON	Connects between the internal and external grounds.

Note 1: Settings of Circuits 1 and 2 should be identical, disregarding it is ON or OFF. These two circuits do not function if inconsistently set (disregarding ON or OFF).

NOTE Circuits 2 and 3 of the DIP switch
Do not turn the circuits 2 and 3 to ON as much as possible except when it is unavoidable because any external power supply can not be used. If doing so, malfunction may occur due to electrical interference.

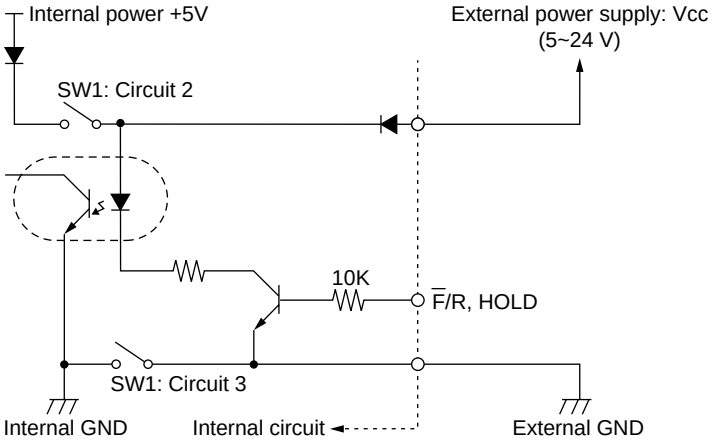
3) Output signal



- Positive-true logic output by open collector
  Voltage: 30V max., Drawing current: 10 mA max.
- External resistance R: (Vcc /10) KΩ ≤ R≤ 10 kΩ

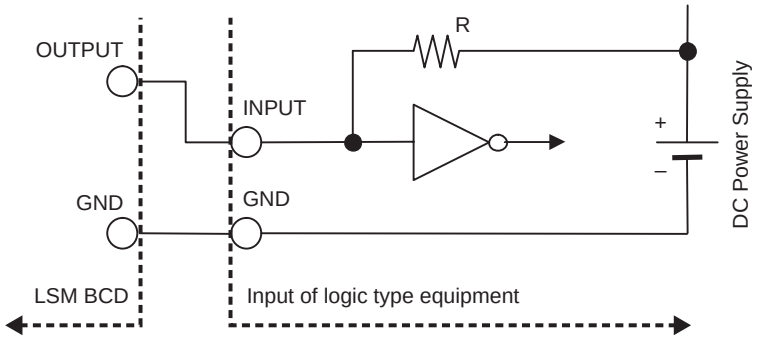
Pin No.	Signal name	Remarks
1~28	DATA	Output of 7-digit measurement data (possible to select whether by positive-true logic or by negative-true logic)
29	ERR-0	Output of segment error (positive-true logic)
32	$\overline{\text{STB}}$	Output of strobe (acknowledgment) (negative-true logic)
34	+POLE	Output of sign • HIGH level: Positive (+) data • LOW level: Negative (-) data

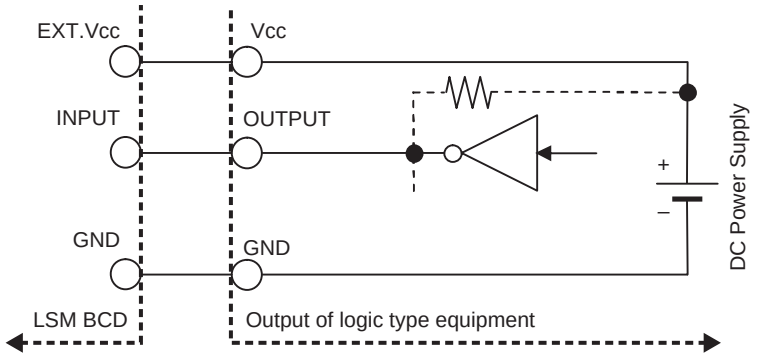
4) Input signal



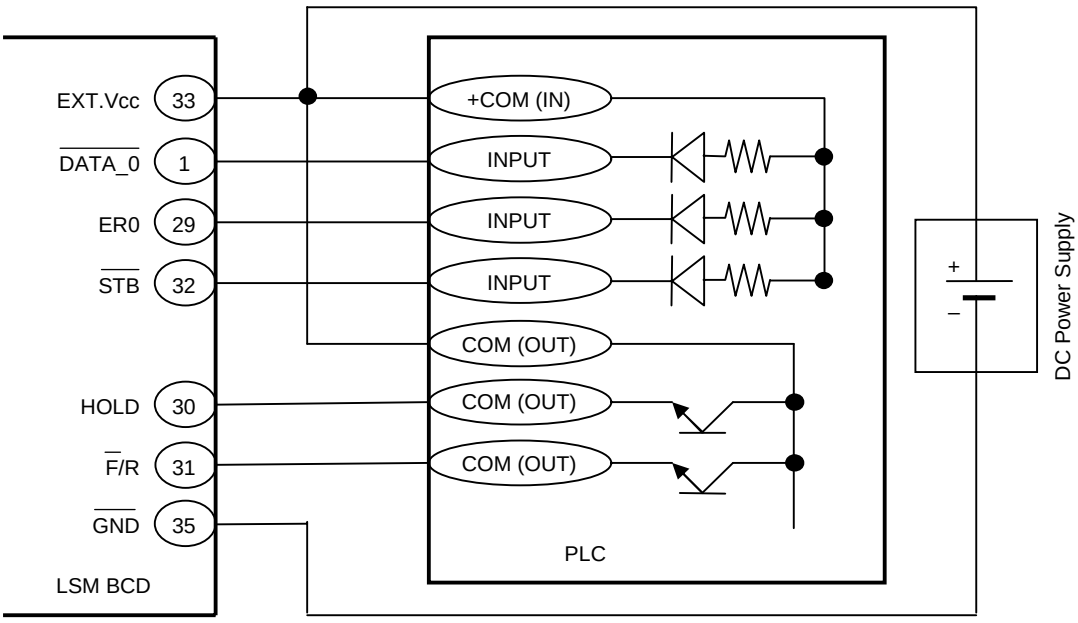
Pin No.	Signal name	Remarks
30	HOLD	• Does not hold the data when the circuit is open or the line level falls to LOW. • When the line level rises to HIGH, the previous data will be held (latched) and the update does not take place. In order to read the data at a desired point in time irrespective of the $\overline{\text{STB}}$ signal, start the read at least 500 µs after the input of HOLD signal.
31	$\overline{\text{F}}$/R	This is valid in simultaneous measurement. • Selects $\overline{\text{F}}$ (foreground program No.) when the circuit is open or the line level falls to LOW. Selects R (background program No.) when the line level rises to HIGH.

• Example A: Connect to logic





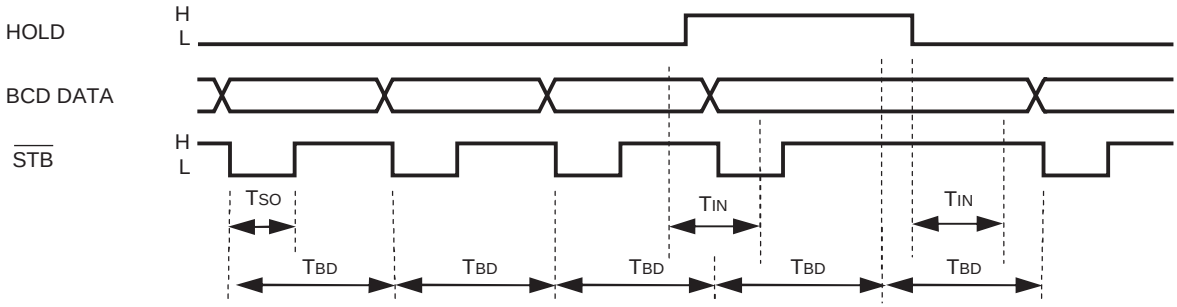
• Example B: Connect to PLC (Programmable Logic sequence Controller)



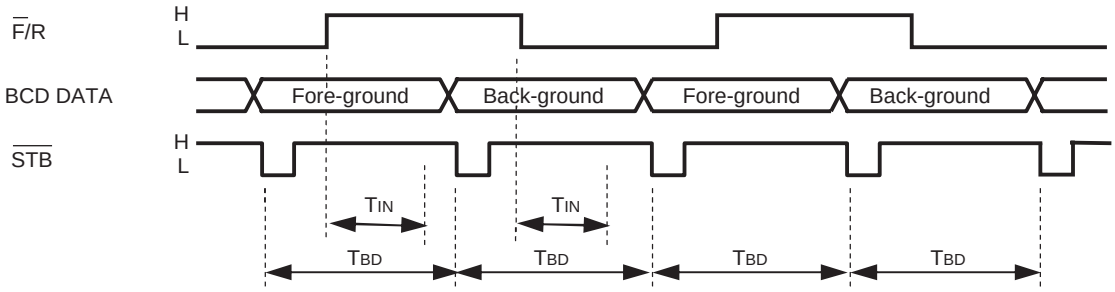
• The input of PLC must be plus common type.
  The output of PLC must be plus common type.
• There must be Transistor type input or output. Do not use Reray type.

5) Timing chart

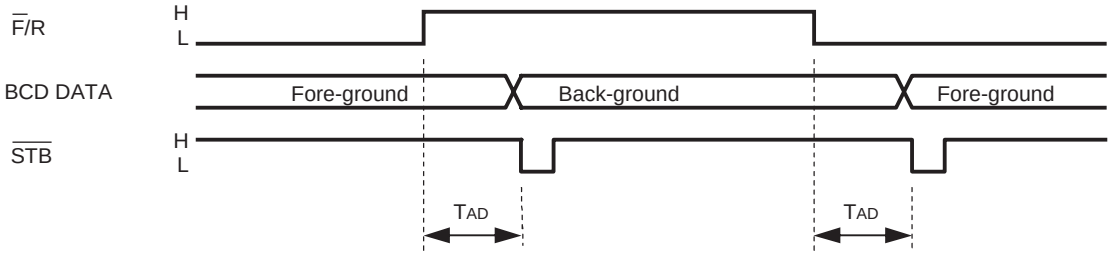
• BCD : Ready state in normal measuring mode.



• BCD : Ready state in simultaneous measuring mode.



• BCD: Ratch state in simultaneous measuring mode.



Refer to Section 6.2.2.3 for TBD, TIN, Tso, and TAD.

TIP

1. Data output timing
   - Input signals (F/R, HOLD) will be checked just before starting the data output.
   - In the continuous-run-measurement, “TBC” is instead of “TBD” for timing chart.
   - In the event of Err-0, data of “0” will be output.
   - During a setup mode, output data is indefinite.
2. While the HOLD signal is on, measured data will be kept.
3. Note that meaningless data may be outputted, if the F/R signal is switched in a single measurement (not a simultaneous measurement).
4. By the F/R signal it is possible to switch between the foreground and background data during the display is latched.

6.2.4 GP-IB interface

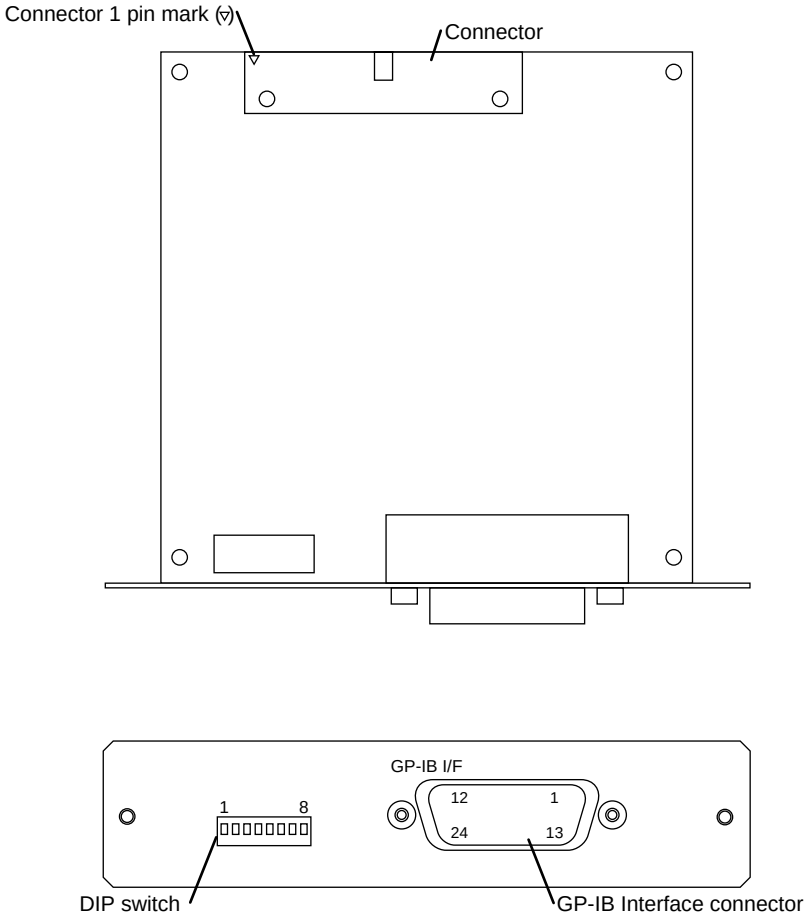
- This interface unit conforms to the IEEE standard 488-1978.
- The subset of this interface does not include the controller function. Consequently, it can not output data directly to a printer with a GP-IB interface.

6.2.4.1 Method of use

1) Installation and setup of the interface

- By referring to Section 6.2.4.3 “Specification”, set my-address and delimiter.
- Install this interface unit in the Display Unit. For the installation method, refer to Section 6.3 “Installing the Optional Interface Unit”.

6.2.4.2 Name of each part

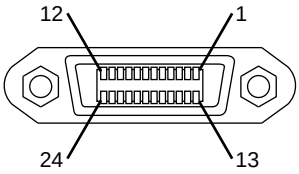


Consisting of	Quantity
GP-IB interface	1
Connecting cable	1

6.2.4.3 Specification

1) Specification

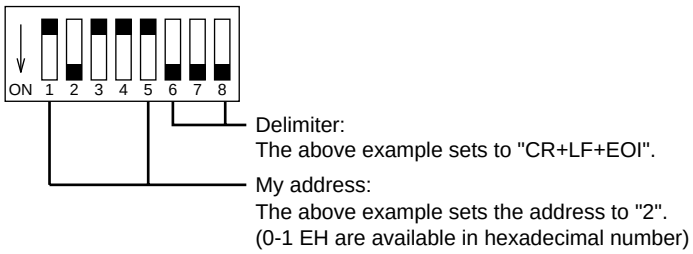
- Pin assignment



Pin No.	Signal name	Pin No.	Signal name
1	DI01	13	DI05
2	DI02	14	DI06
3	DI03	15	DI07
4	DI04	16	DI08
5	EOI	17	REN
6	DAV	18	GND
7	NRFD	19	GND
8	NDAC	20	GND
9	IFC	21	GND
10	SRQ	22	GND
11	ATN	23	GND
12	F.G. (Frame GND)	24	GND (Signal GND)

- Applicable connector
  IEEE-488 based.

2) DIP switch settings



- List of delimiters

Delimiter	Circuit		
	6	7	8
CR+LF	ON	ON	OFF
CR	ON	OFF	OFF
LF	OFF	ON	OFF
CR+LF & EOI	ON	ON	ON
CR & EOI	ON	OFF	ON
LF & EOI	OFF	ON	ON
EOI	OFF	OFF	ON

TIP

- What is “My address” ?
  Each of the commonication devices which are on the same GP-IB has an specific address (number) with which it is identified.
- What is a “delimiter” ?
  The delimiter is a signal (or a set of signals) that represents the end of the data.

6.2.4.4 Functions

The GP-IB interface functions include the following.

Interface function	Application	Function
SH1: Source Handshake	—	Functions to synchronize transmission with the data bus operation by handshaking with a device equipped with an AH function
AH1: Acceptor Handshake	—	Functions to synchronize reception with the data bus operation by handshaking with a device equipped with an SH function
T6: Talker	Basic Talker	Function to transmit data for other devices
	Serial Poll	Function to transmit a status byte, which represents the talker condition, for the controller
	Cancelling talker by MLA.	Function for automatically canceling the talker function and setting the listener function by MLA message.
L4: Listener	Basic Listener	Function to receive data from another device
	Cancelling listener by MTA.	Function for automatically canceling the listener function and setting the talker function by MTA message.
SR1: Service Request	—	Function to inform the controller of an event occasion, and, as a consequence, request special service from the controller
RL1: Remote Local	Basic Remote Local	Function to select the method of device control; either by local (manual) or interface information
	Local Lockout	Function to prohibit the device from returning to the local mode.
DT1: Device Trigger	—	Function to prompt the selected device to execute a specified operation

TIP What is “serial poll” ?

- The controller which receives an SRQ (Service Request) will call the talkers that it assumes are transmission sources. When the addressed talker transmits a status byte (8-bit data) back to the controller to represent the talker condition, the controller will check each byte to identify the source talker.
  When the controller calls a talker for this purpose, it sends an SPE (Serial Poll Enable) to the talker to discriminate from general addressing to the talker.
- SRQ status byte
  In the serial poll state the GP-IB interface unit indicates the reason for issuing an SRQ with the following bit contents:

bit contents / Item	bit7 (MSB)	bit6	bit5	bit4	bit3	bit2	bit1	bit0 (LSB)
OK	0	RSV	0	0	0	0	0	0
ERROR	0	RSV	0	0	1	Error No.		
DATA	0	RSV	0	1	0	NG	GO	1

• RSV becomes “1” when this interface is in the service request state.

6.2.4.5 Operations

1) The GP-IB interface unit for the LSM is basically a listener that receives various commands, and a talker that transmits response commands. For further information on reception commands and response commands, refer to the description in Sec. 6.1.2.4.

2) When receiving an IFC (Inter Face Clear), the GP-IB interface is initialized.
   - Remote state will be canceled to local state.
   - Local lockout state (LLO) will be canceled.
   - Service request (SRQ) transmission will be disabled.

3) When the GP-IB interface receives an REN (Remote ENable) signal followed by other commands, the interface enters the remote state. In the remote state, only the [C] key can be operated.

4) When the GP-IB interface receives an LLO (Local LOckout) as a multi-statement and other commands, the interface enters into local lockout state. In this local lockout state, all the key operations are prohibited.
   (This state can be released by inputting an IFC (Inter Face Clear) from the host computer.)

5) However in the remote state or local lockout state, I/O operations, except for key entries, will operate as usual.

6) When the GP-IB interface receives a GET command) as a multi-statement, the single-run measurement or zero-run measurement will commence.
   Zero-run measurement can be terminated by inputting another GET command.

7) This interface unit (as a talker) does not output unless a transmission command has been received.

8) When this interface unit receives an SRQ command, it is ready to transmit the service request and the SRQ lamp lights.
   - When this interface transmits a response (sending data from this interface), send a service request signal (SRQ) to ready the controller for data reception.
   - When the GP-IB interface receives an SPE (Serial Poll Enable) from the controller, the interface outputs the SRQ status byte on the data bus, which describes the content of the request.
   - In the service request state, the interface does not output the OK or ER0 – 7 commands as a response command, but only sends the SRQ status byte to describe the conditions.

9) Just after power on transmit a “CL” command as the first communication command and repeat this until a response of “OK” is received.

6.2.5 Dual-type add-on unit

With this dual-type add-on unit it is possible to perform dual-unit measurement using the same model of two Measuring Units at once.

On detail specification and installation, please refer to the user's manual of the dual type add-on unit.

6.3 Installing the Optional Interface Unit

For this system it is possible to select either of the Second Analog I/O, BCD, and GP-IB interfaces, as well as one dual-type add-on unit and one Digimatic Output Unit concurrently.

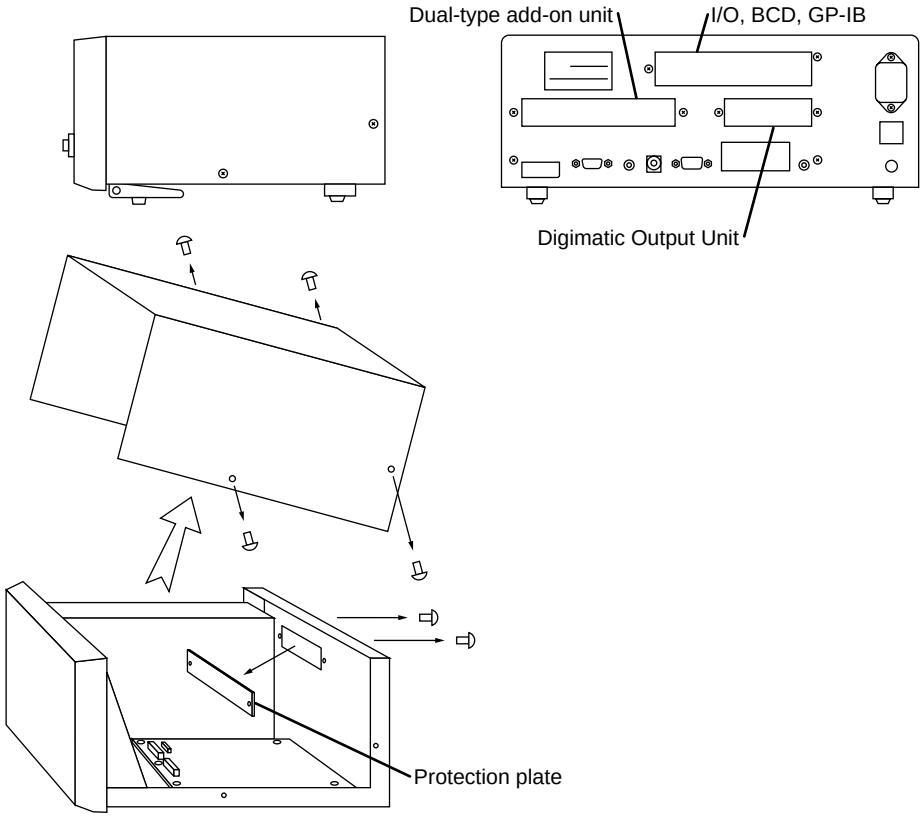
When installing in the Display Unit the above listed units use the same procedure as shown below.

CAUTION

Observe the following to avoid electric shock.

1. If an optional interface needs to be installed inside the Display Unit, unplug the power cord from the inlet and put the power switch in the OFF position, then pull off the key switch.
2. Do not remove the protective cover on which the seal is stuck to. Otherwise, an electric shock may result.
3. Do not remove the seal, shown at the left.

1) Safety check
   - Turn the power key switch to off position (marked as “O”), then remove the key switch.
   - Unplug the power cord from the inlet on the rear panel of the Display Unit.



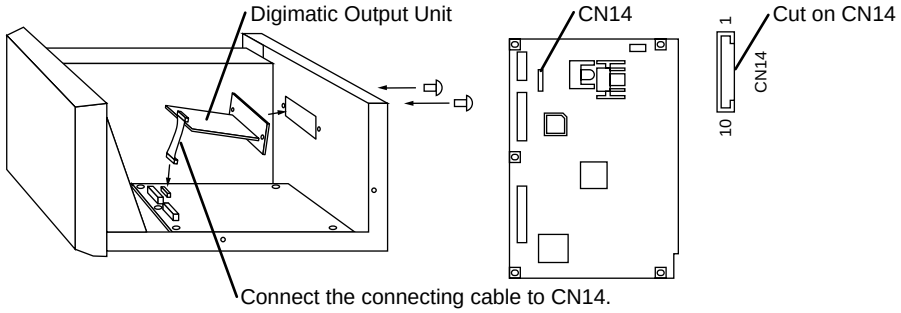
2) Removing the cover
   Remove four screws on both sides of the cover and take out the cover.

3) Installing the interface
- If installing more than two optional interfaces, install them in the order below:
  a. Digimatic Output Unit
  b. Second Analog I/O, BCD, or GP-IB interface
  c. Dual-type add-on unit
- Remove the protection plate from where each interface is to be installed.
- Install each interface unit inside the display unit following 6.3.1 through 6.3.2.
- Be sure to tighten the fixing screws of each interface unit.

4) Replacing the cover
Replace the cover which has been removed at step (2) and fit it with four screws.

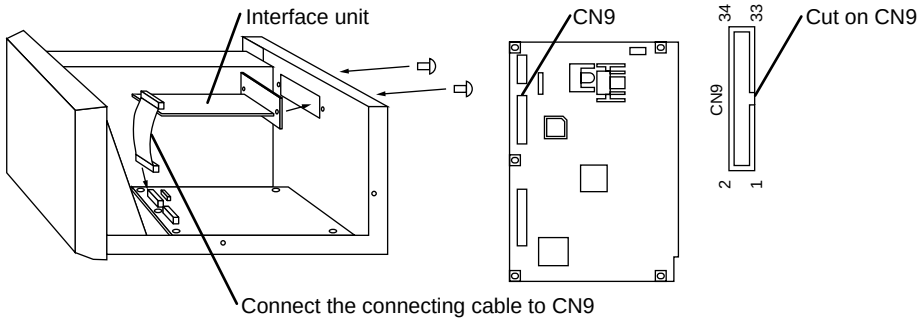
6.3.1 Digimatic Output Unit

- Using the provided connecting cable, connect the Digimatic Output Unit to connector CN14.
- Fit the connecting cable to the cut on the connector CN14 and firmly connect them.
- Firmly tighten the Digimatic Output Unit mount plate with two screws as shown.



6.3.2 Second Analog I/O, BCD, and GP-IB interfaces

- Using the provided connecting cable, connect the interface unit to connector CN9.
- Fit the connecting cable to the cut on the connector CN9 and firmly connect them.
- Firmly tighten the Interface Unit mount plate with two screws as shown.



7 INSPECTION AND MAINTENANCE

This chapter describes the method of maintenance and troubleshooting, as well as the contents of the error messages and remedies.

7.1 Display Unit

The Display Unit will, if it is turned on, perform a self-check.

7.1.1 Display check

- If the power is on, display check mode is entered.
  All LEDs and display sections turn on and then turn off. Then digit 8 turns on successively [888···8] from the upper display section: during which check the display elements if they are normal and uniform in intensity.
- Internal circuit checking is carried out and if found to be normal, LD1 ON LED turns on (LD1 ON and LD2 ON LEDs turn on if performing dual-unit measurement). Then the BUSY LED starts flashing and measurement will start from the ready state.
- Error message will be displayed if abnormality is detected during selfcheck of the internal circuit. For details of error message, refer to 7.3, “Error Messages and Remedies”.

7.1.2 Cleaning method

If the Display Unit is contaminated, unplug the power cord from the inlet first, then wipe lightly with a soft dry cloth for the operator’s safety.

7.2 Error Messages and Remedies

The table below lists the error messages and their remedies.

Display	Meaning	Remedies
Err-0	Segment error • There is no measuring object that corresponds to the specified segment. • Shutter is closed. • Laser does not come into reception unit. • Laser characteristic may be deteriorated.	• Check if a workpiece is present. • Check the segment settings. • Make sure that the connection cable is connected between the Emission Unit and Reception Unit. • Open the shutter. • Be sure to align the optical axis correctly, if the Emission Unit and Reception Unit are separated from the mount. For details, refer to the measuring unit user's manual. • Check the LD ON LED.
Err-1	Setup item error • There is a certain conflict in the setup data.	• Press the C key to clear the error message. • Previously setup contents are lost. Redo setup from the beginning.
Err-2	Calibration error • Incorrect segment setting • A value significantly different from the dimension of the reference gage is entered. • The HIGH CAL setting value is too close to the LOW CAL setting value.	• Press the C key to clear the error message. • Redo the segment setting again. • Cancel the setting value, then set it again. For information about the cancellation procedure, refer to Section 4.1, "Calibration".
Err-5	Setup value error: • The upper limit value is set lower than the lower limit value, or HIGH CAL ≤ LOW CAL. • Input the unacceptable value.	• Clear the error message by pressing the C key. • Clear the wrong setup values and re-enter the correct values.
ERR-ID 701234	Inconsistent ID unit serial data • Serial numbers are not consistent between the ID unit and Measuring Unit.	• The ID unit has a unique number for each Measuring Unit. Always mount the ID unit that has the same serial number as the Measuring Unit to be used. • Turn off the power and mount a correct ID unit.
ERR-ID 000000	• Signal cable is not connected. • Incorrect measuring unit is connected.	• Turn the off power and connect the signal cable. • Connect the Display Unit to the appropriate Measuring Unit.
ERR-SB Err-8	Laser does not scan. • Signal cable is not connected. • Short-circuiting pin is not inserted in the remote interlock connector. • Laser diode is deteriorated. • Scanner motor is not running.	• Turn off the power and connect the signal cable. • Insert the short-circuiting pin. • Contact the nearest dealer or Mitutoyo sales representative.
LD 1 ON LD 2 ON	Laser diode anomaly (LD ON LED is flashing.) • The laser diode is forced to operate below a temperature outside the specified range. • Laser diode begins to deteriorate.	• Using the laser diode at a high temperature reduces efficiency and accelerates deterioration in addition to drawing a large current. Take appropriate measures to cool the diode. • Contact the nearest dealer or Mitutoyo sales representative.
EEEEEEEEEEE	• The dummy ID unit is installed. • Internal circuit error.	• Replace the dummy ID unit with the ID unit supplied with the measuring unit. • Contact the nearest dealer or Mitutoyo sales representative.
Prt Err	Printer error • Cable is not connected or broken. • Communication conditions are not consistent.	• Check the cable connection.
dCU Err	Setup value error: • Cable is not connected or broken.	• Check the cable connection. When the printer is not used, set to NONE in the basic setup.
Err-10	Stained protection glass has been detected. (In the case where the stained protection glass detection function has been set.)	• Clear the message by pressing the C key. • Clean the protection glass, referring to the measuring unit user's manual.
Lo24	Abnormal power supply • Low line voltage • Power supply is adversely affected by a surge current, etc.	• Turn on the power again. • If this indication is repeated, check the line voltage for any abnormality such as a level drop and/or interference noise.

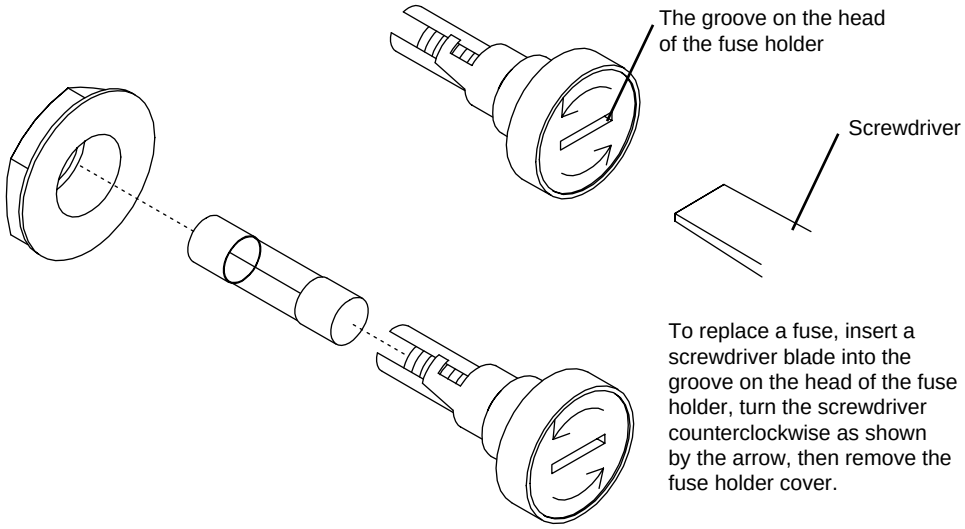
7.3 Troubleshooting and Remedies

The following table shows the troubleshooting and remedies on the LSM system.

Symptoms	Possible causes	Remedies
The LSM does not start if the power is turned on.	• Extra power supply (+24V) is off or failed. • Extra power supply cable is not connected.	• Check the external power supply. • Check the external power supply cable.
Measurements are unstable, resulting in a poor accuracy.	• Warm-up of the system is insufficient. • Measuring Unit is directly subjected to sunlight or air flow from the air conditioner. • Contaminated protection glass. • Vibration of workpiece. • Laser diode power is reduced.	• Warm up the system at least 20 to 30 minutes. • Take measures to avoid the system from being subjected those troubles. • Clean the glass by referring to Section 8.2. “Measuring Unit” • Set a larger number of scans. • Check the LD ON LED is flashing. If it does, contact Mitutoyo or the nearest sales representative.
Measuring error persists even after calibration	• Contaminated protection glass.	• Clean the glass by referring to the measuring unit user's manual.
Statistical processing can not be achieved.	• Single-run measurement, continuous-run measurement, or zero-run measurement has not been performed. • “ST” command is not sent through RS-232C.	• Perform the single-run measurement, continuous-run measurement, or zero-run measurement. • Send the “ST” command.
The system incorrectly operates.	• The system is electrically interfered.	• Make a positive grounding, and use a shielded-wire cable for the I/O analog interface. Lay this cable sufficiently away from the source of interference. • The external power supply should be drawn from a line with little electrical interference.
Measurement does not terminate while [- - - - - - -] is displayed.	• The number of samples in the sample measurement it too large. • Under the use of abnormal value eliminating function the workpiece dimension is significantly different from the setup value.	• Stop the measurement with the [C] key and set a smaller number of samples. • Check the setup value
Measurement interval does not match the measuring conditions.	• Under the use of the abnormal value eliminating function the workpiece dimension is significantly different from the setup value.	• Check the setup value.

7.4 Fuse replacement

- Before replacing a fuse, turn the power switch to OFF and unplug the power cord from the inlet for safety.
- Always use fuses that have the specified rating.
- Refer to the following diagram for the replacement procedure.



8 SPECIFICATIONS

This chapter describes the specifications and supplied accessories of the LSM-6200 Display Unit.

8.1 LSM-6200 Display Unit

(1) Specifications

Code No.	mm/E	544-071	
	mm/inch	544-072	
Model No.	LSM-6200		
Display	Fluorescent display 16-digit + 11-digit, Guidance LEDs		
Measuring functions	Segment designation	1 to 7 (1 to 3 for Transparent)	
	Edge designation	1 to 255	
	Averaging method	Arithmetical averaging	8 to 2048
		Moving averaging	32 to 2048
	Tolerance judgment (GO, ±NG) ; Multi-limit judgment (7classes) ; Preset/Zero-set ; Mastering ; Abnormal data elimination ; Automatic workpiece detection ; Reference value setting ; Data output condition ; Laser power deterioration ; Sample measurement ; Statistical processing ; Dual-program measurement ; Automatic measurement using edge mode ; Workpiece position display ; Transparent object measuring (Segment : 1 to 3); Key-lock function ; mm / inch changeover ; Dual-gauge calibration ; Selection of resolution ; Display of a comma to mark the thousandths position ; Judgment in ready state ; None-display unnecessary digits ; Distinction of measurement part model ; Buzzer ; Tolerance judgment (GO, ±NG) in a standby state +Analog output ; Group judgment ; Fine wire measurement (only LSM-500S); Dual-Measurement (Two measurement part connection)(Option); Drill / End mill (Odd number edge) outer-diameter measurement; The number of programs:100;		
Scanning signal monitor connector	Provided as standard (with the plug)		
Remote interlock connector	Provided as standard (with the plug)		
Power switch	Key switch used		
Built-in interface	RS-232C ; Foot switch connector ; I/O analog interface		
Optional interface	DCU slot	Digimatic code output unit (2-ch)	
	Option slot (1-slot)	2nd I/O analog I / F ; BCD I / F ; GP-IB I / F ;	
Power supply	AC100V to 240V±10%, 50 / 60Hz, 50W		
Operating environmental	Temperature	0°C to 40 °C	
	Humidity	35%RH to 85 %RH [without condensation]	
	Altitude	2000m or less	
Storage environmental	Temperature	-15°C to 55°C	
	Humidity	35%RH to 85 %RH [without condensation]	
Mass	Approx. 5kg		
Safety	Compliance with EN61010-1 (OVER VOLTAGE CATEGORY II, POLLUTION DEGREE2)		

(2) Standard Accessories

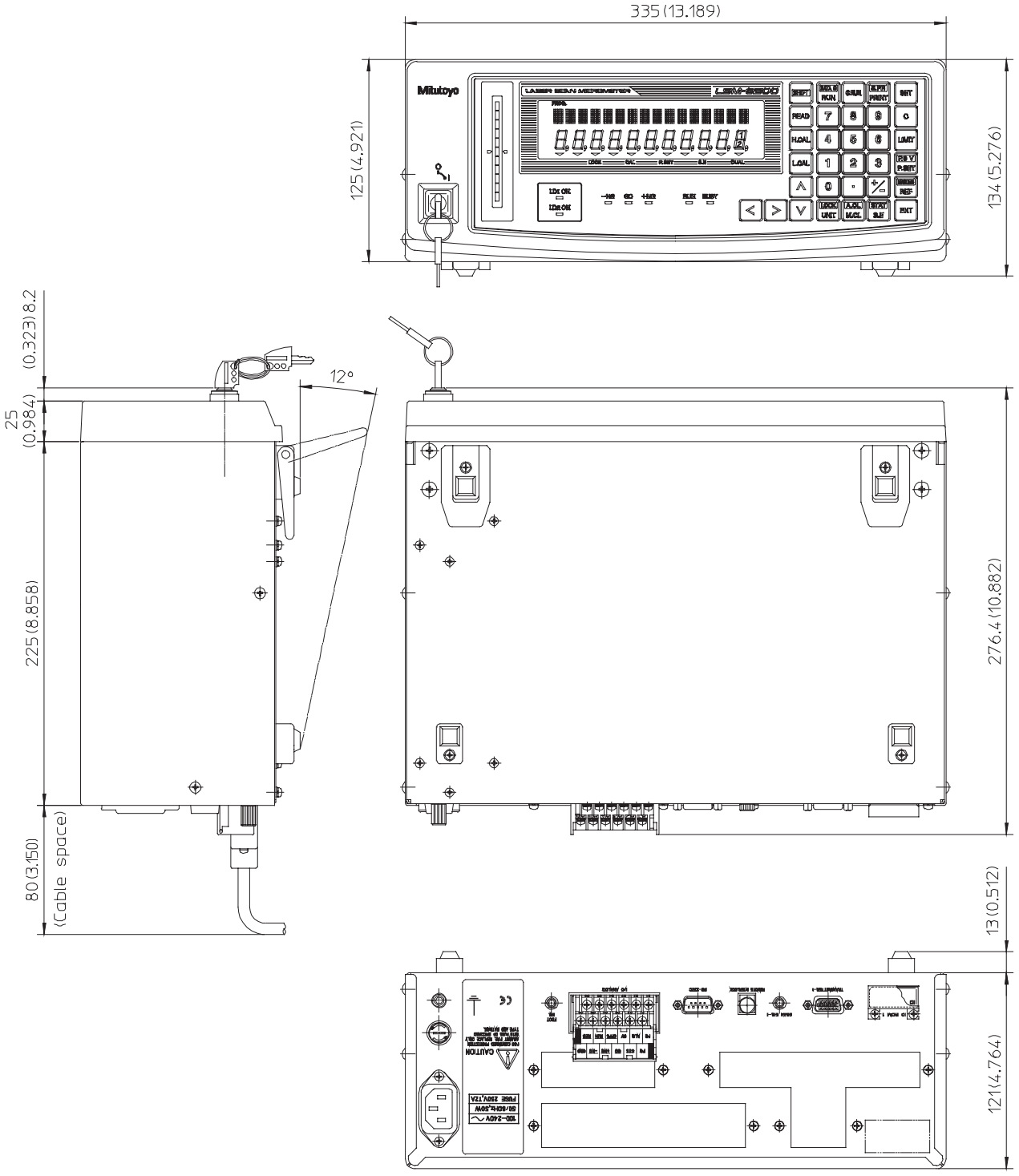
Part No.	Item	Qt.
—	Power cord [Note]	1
02ADC020	GND lead wire	1
956042	Short-circuiting pin for remote interlock connector (delivered as mounted on the display unit)	1
214938	Remote interlock connector (MP-121M:MARUSHIN)	1
02AGC401	Scan signal monitoring connector (MP-105LC:MARUSHIN)	1
C124-057	Fuse 2A (Time lag)	1
02AGC604	Power key switch	2
99MBC095A	User's Manual	1

Note: Depending on delivered country.

(3) Optional Accessories

Part No.	Item
02AGP150	Dual-type add-on unit for LSM-6200
02AGC840	Digimatic Output Unit Interface (with two channels)
02AGC880	Second Analog I/O Interface
02AGC910	BCD Interface
02AGC940	GP-IB Interface
02AGD600A	Printer & cable set: DPU-414-30B + PW-4007-J1 (100 VAC, for domestic use)
02AGD600B	Printer & cable set: DPU-414-30B + PW-4007-U1 (120 VAC, for U.S.A.)
02AGD600C	Printer & cable set: DPU-414-30B + PW-4007-E1 (230 VAC, for Europe)
223663	Printer paper (10 rolls)
936937	Digimatic Output Unit cable
937179T	Foot switch

(4) External view and dimensions



MEMO

9 RESTRICTIONS ASSOCIATED WITH THE COMBINATION OF FUNCTIONS, TABLES OF THE BASIC SETUP MODES

This chapter describes the restrictions associated with the particular combination of functions. It also describes the setup modes using tables.

9.1 Restrictions Associated with the Particular Combination of Functions

The following restrictions exist for function combinations.

1. Restrictions on the combination of functions for single-unit measurement and single measurement are as follows.

Functions combinations		Edge specification: Manual measurement	Edge specification: Automatic measurement	Transparent object measurement	Ultra-fine wire measurement	Automatic workpiece detection	Abnormal value elimination	Sample measurement	Odd-numbered-edge cutting tool measurement	Moving average	Group judgment
Edge specification	Manual measurement		–	–	–	○	○	○	–	○	○
	Automatic measurement	–		–	–	○	–	–	–	–	–
Transparent object measurement		–	–		–	○	○	○	○	○	○
Ultra-fine wire measurement		–	–	○		–	○	○	–	○	–
Automatic workpiece detection		○	○	○	○		○	○	–	–	○
Abnormal value elimination		○	–	○	○	○		○	○	○	○
Sample measurement		○	–	○	○	○	○		○	○	○
Odd-numbered-edge cutting tool measurement		–	–	○	–	–	○	○		–	○
Moving average		○	–	○	○	–	○	○	–		–
Group judgment		○	–	○	–	○	○	○	○	–	

TIP1: "○" indicates permitted combinations, and "—" indicates combinations that are not permitted.
TIP2: The averaging number setting is limited to between 16 and 2048 for ultra-fine wire measurement.
TIP3: The averaging number setting is limited to between 32 and 2048 for moving averaging mode.
TIP4: The segment number setting is limited to between 1 and 3 for measurement of a transparent object.

2. The following restrictions are applied to the combination of functions depending on the number of Measuring Units to be used.

		Single measurement				Simultaneous measurement			
Number of Measuring Units Type of dual-unit layout		1 unit	2 units			1 unit	2 units		
			DW	DXY	DF		DW	DXY	DF
Edge specification	Manual measurement	△	△	—	—	—	—	—	—
	Automatic measurement	△	—	—	—	—	—	—	—
Transparent object measurement		△	△	△	△	△	△	△	△
Ultra-fine wire measurement		△	—	—	—	—	—	—	—
Automatic workpiece detection		△	—	—	—	—	—	—	—
Abnormal value elimination		△	△	△	△	△	△	△	△
Sample measurement		△	△	△	△	△	△	△	△
Odd-numbered-edge cutting tool measurement		△	—	—	—	—	—	—	—
Moving average		△	△	△	△	—	—	—	—
Group judgment		△	△	△	△	—	—	—	—

TIP1: "△" indicates permitted combinations under the restrictions shown in the "a." section. "—" indicates combinations that are not permitted.
TIP2: The averaging number setting is limited to between 16 and 2048 for ultra-fine wire measurement.
TIP3: The averaging number setting is limited to between 32 and 2048 for moving averaging mode.
TIP4: The segment number setting is limited to between 1 and 3 for measurement of a transparent object.

9.2 List of Setup Modes

Tables in the following are the list of setup modes. Use these tables to check the setup data.

1. Make a check in the squares at the left of the mode number or in the setting content column that need to be setup.
2. Fill in the setup values for the underlined part.
3. If these setup values are frequently changed, make copies of these forms.

9.2.1 List of basic setup modes

[Basic setup mode]

Mode No.	Setup item	Guidance	Setup contents	Default setup
B0	a: Resolution	RES	☐0 : 0/☐1 : 1/☐2 : 2/☐3 : 3/ ☐4 : 4/☐5 : 5/☐6 : 6/☐7 : 7	0
	b: Number of blank-out digits	BLN	☐0 : No blank-out/☐ 1 : 1 digit/☐2 : 2 digits	0
	c: Mark of thousandth digit	(.)	☐NONE: No mark/☐USE : Mark	NONE
	d: Buzzer sound Note: System error alarm can not be prohibited.	BUZZER	☐ALL : Sounds at any event. ☐KEY : Sounds when key input is made (indicating acceptance or operation error). ☐NG : Sounds when a NG measurement results. ☐NONE: Does not sound except a system error alarm.	ALL
	e. Display latch timer	LATCH	☐_____sec.	10
B1	a. Output in the ready state	D.OUT	☐NONE: Neither GO/NG judgment nor analog output is made/ ☐OUT : Both GO/NG judgment nor analog output are made	NONE
	b. Analog output voltage at Err-0	ERR-0 V	☐ 0 : Output voltage 0V/☐ +5 : Output voltage +5V ☐-5 : Output voltage -5V	0
	c. Message in the event of Err-0	ERR-0 D	☐ERR-0: Displays “Err-0”. ☐0 : Displays “0”.	ERR-0
	d. Message at the start of me asurement	RUN D	☐-------- : Displays “-------” ☐PREV.D : Displays the previous data	--------
	e. Method of average	AVG.M	☐ARITHM: Arithmetic average /☐MOVING : Moving average	ARITHM
	f. Method of GO/NG judgment	JDG.M	☐LL-LH : Judges with the lower limit and upper limit ☐L1-L6 : Judges by multi-stage selection ☐N-UL : Judges with the target value + tolerance	LL-LH
		(COPY)	g. Method of using the target value and reference value ☐NONE : Does not copy the target value on the reference value ☐NO-REF : Copies the target value on the reference value	(NONE)
B2	a. Workpiece type	WORK.P	☐OPAQUE : Opaque object ☐TRANS : Transparent object	OPAQUE
	b. Ultra-fine wire measurement	FINE	☐FINE : Performs ultra-fine wire measurement. ☐NONE : Does not perform ultra-fine wire measurement.	FINE
	c. Simultaneous measurement	PROG	☐SINGLE : Single measurement ☐DUAL : Simultaneous measurement	SINGLE
	d. Dual-unit measurement	TYPE	☐DW : DW type /☐DXY: DXY type /☐DF : DF type ☐NONE : Measuring Unit suspended (use only measuring unit-1)	DW
		(CALC)	e. Calculation on DXY-type ☐(X+Y) : Sum/☐(X+Y)/2 : Mean ☐(X-Y) : Difference ☐(X-Y)/2 : Half of the difference	(X+Y)
	f. Method of segment designation	SEG	☐SEGMENT : Segment specification ☐EDGE : Edge specification	SEGMENT
B3	a. Abnormal value elimination	ABE	☐NONE : Does not use ☐USE : Use.	NONE
	b. Automatic workpiece detection	AWDT	☐NONE : Does not use. ☐DIA : OD detection /☐ POSITN: Position detection	NONE
		(SCAN)	c: Number of scans ☐16 : 16 times /☐1 : 1 time	(16)
	d. Group judgment	GTJ	☐NONE : Does not use/☐USE : Uses	NONE
		GTJ D	e. Setting the group judgment result output ☐NONE : Does not output/ ☐OUT : Outputs.	(NONE)
	e. Odd-numbered-edge cutting tool measurement	TOOL	☐NONE : Does not use ☐USE1 : Using the SEG1 side as the reference. ☐USE3 : Using the SEG3 side as the reference.	NONE

Mode No.	Setup item	Guidance	Setup contents	Default setup
B4	a. RS-232C port	RS-232C	☐ COM : Use for communication with PC ☐ PRN : Use as a printer port (GP-IB is also available) ☐ NONE : Does not use. (GP-IB is also available)	COM
	b. Baud rate	BAUD	☐ 9600 / ☐ 19200 / ☐ 38400 / ☐ 4800	9600
	c. Data bits	LENGTH	☐ 8 : 8 bits / ☐ 7 : 7 bits	8
	d. Parity check	PARITY	☐ NONE : Does not use / ☐ ODD : Odd parity ☐ EVEN : Even parity	NONE
	e. Delimiter	DELIMT	☐ CR+LF : CR + LF / ☐ CR : CR / ☐ LF : LF	CR+LF
	f. Line control	CONTRL	☐ NONE : Does not use / ☐ USE : Uses.	NONE
B5	a. I/O RUN input	RUN	☐ S.RUN : Triggers single-run measurement ☐ T.RUN : Triggers continuos-run measurement with term specification ☐ C.RUN : Triggers continuos-run measurement	S.RUN
	b. I/O PSET input	PSET	☐ PSET : Enables offset function. ☐ HOLD : Enables HOLD function.	PSET
	c. I/O GO output	GO	☐ GO : GO output / ☐ STB : STB output ☐ ACK : ACK output	GO
B6	a. Use of DCU	DCU	☐ NONE : Does not use / ☐ DCU1 : Uses only OUTPUT-1. ☐ BOTH : Uses both OUTPUT-1 and OUTPUT-2.	NONE

[Expanded basic setup mode]

Mode No.	Setup item	Guidance	Setup contents	Default setup
B0 to B6	General items			
B7	a. Use of expanded items	ADD	☐ NONE : Does not use/☐ USE : Uses.	NONE
	b. —	SEG LIM	Space for additional functions (not for ordinary use)	0
	c. —	SEG ERO	Space for additional functions (not for ordinary use)	0
	d. —	SEG COR	Space for additional functions (not for ordinary use)	NONE
	e. Setting the SHL	SHL	☐ _____ % (Integer between 5 and 95)	50
	f. Setting for detecting dirty protection glass	DIRT	☐ NONE : Does not use/☐ USE : Uses.	NONE
	g. Setting the measuring method	DLC	☐ NONE / ☐ ON / ☐ OFF Note: Select " OFF " only when "e. Setting the SHL" is to be modified.	NONE
	h. —	A.5V	Space for additional functions (not for ordinary use)	0
	i. —	A.0V	Space for additional functions (not for ordinary use)	0
	j. —	A2.0V	Space for additional functions (not for ordinary use)	0
	k. Setting the STB length	STB	☐ [redacted] / ☐ [redacted] / ☐ [redacted] / ☐ [redacted] / ☐ [redacted] ☐ [redacted] [redacted] / ☐ [redacted] / ☐ [redacted] [ms]	MR
	l. Setting the input signal filter	IFF	☐ [redacted] / ☐ [redacted] / ☐ [redacted] [ms]	5
	m. Application range of calibration	CAL	☐ ALL : Applied to all programs ☐ CH : Applied to each channel	ALL
	n. Application range of presetting and mastering	PST	☐ PRG : Applied to each program ☐ CH : Applied to each channel ☐ ALL : Applied to all programs	PRG
	o. Number of programs to be used	PRGM	☐ 100 : 100 programs/☐ 10 : 10 programs	100

9.2.2 List of calibration functions

Item	Setup item	Setup contents	Setup range	Default setup
CAL	HIGH CAL	☐ HC : HIGH CAL gage = _____	Max.7 digits in the positive direction only.	Cancel (0)
	LOW CAL	☐ LC : LOW CAL gage = _____	Max.7 digits in the positive direction only.	Cancel (0)

9.2.3 Reading in the amount of light

Item	Setup contents	Setup range	Default setup
Light amount detection	☐ AUTO : Automatically performs light amount detection. ☐ READ : Reading in the light amount.		AUTO

9.2.4 List of function setup modes

Program No. = _____

Mode No.	Setup item	Guidance	Setup contents	Setup range	Default setting
F0	Segment specification*	SEG	Segment No. = _____	Max. 7 positions	1
	Edge specification*	EDG	Use of automatic measurement	—	NONE
			☐ NONE : Manual measurement		(1 to 2)
			☐ PIT : Automatic pitch measurement		(2 to 5)
			☐ DIA : Automatic OD measurement		(2 to 3)
			☐ GAP : Automatic gap measurement		(3 to 4)
		STRT	Start edge = _____	1 to 254	—
		END	Finish edge = _____	2 to 255	
F1	Arithmetric average	MR ARM	Number of scans for averaging = _____	1 to 2048	1024
	Moving average	MR MOV	Number of scans for averaging = _____	32 to 2048	1024
F2	(Abnormal value elimination)*	EL EH CNT	Lower abnormal limit = _____ Upper abnormal limit = _____ Abnormal count value = _____	Sign + max. 7 digits Sign + max. 7 digits 0 to 999	Free (0)
	GO/NG judgment*	LL LH	Lower limit value = _____ Upper limit value = _____	Sign + max. 7 digits Sign + max. 7 digits	Free (0)
		L1 L2 L3 L4 L5 L6	Multi-limit selection 1 = _____ Multi-limit selection 2 = _____ Multi-limit selection 3 = _____ Multi-limit selection 4 = _____ Multi-limit selection 5 = _____ Multi-limit selection 6 = _____	Sign + max. 7 digits Sign + max. 7 digits Sign + max. 7 digits Sign + max. 7 digits Sign + max. 7 digits Sign + max. 7 digits	Free (0)
		NO LO UP	Target value = _____ Lower tolerance limit = _____ Upper tolerance limit = _____	Sign + max. 7 digits Sign + max. 7 digits Sign + max. 7 digits	Free (0)
F3	Reference value*	REF	Reference value =	Sign + max. 7 digits	Free (0)
		SCL	Scale value =	1 to 3	
F4	Preset	P.SET	Preset value = _____	Sign + max. 7 digits	Free (0)
		DIR	Direction = _____	0 or 1	
	Mastering	OST	Mastering value = _____	Sign + max. 7 digits	Free (0)
F5	Data output condition	DAT O.C	Data output condition = _____	0 to 9	Free (0)
		DAT TIM	Periodic data output timer = _____	0 to 999	
F6	Sample measurement	SMP N	Number of samples = _____	0 to 999	Free (1)
		SMP ITM	Statistical item	—	AVG
			☐ AVG : Mean / ☐ MAX : Maximum value / ☐ MIN :Minimum value / ☐ RNG : Range ☐ (TOOL.D : Odd-numbered-edge cutting tool diameter measurement Odd-numbered-edge cutting tool measurement - outside diameter)* ☐ (TOOL.R : Odd-numbered-edge cutting tool diameter measurement Odd-numbered-edge cutting tool measurement - run-out)*		
		(TOOL.N)	Number of cutting edges of the odd-numbered-edge cutting tool	1 to 999	1
F7	Automatic workpiece detection*	AUT N	Number of measurement times = _____	0 to 999	Free (0)
		AUT TIM	Invalidation period = _____	0 to 9999	
		AUL	Lower detection limit = _____	Sign + max. 7 digits	
		AUH	Upper detection limit = _____	Sign + max. 7 digits	
F8	Group judgment*	GTJ N	Group size subject to judgment = _____	0 to 99	Free (0)
		GTJ ITM	Statistical item applied for group judgment	—	GAG
			☐ GAG : Mean / ☐ GMX : Maximum value ☐ GMN : Minimum value / ☐ GRG : Range		
		GLL	Group lower limit = _____	Sign + max. 7 digits	Free (0)
		GLH	Group upper limit = _____	Sign + max. 7 digits	

* Varies depending on the basic set up.

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